

Date:
User:Monday, 12/05/2008 10:00:47 AM
Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number :	39188		
Estimate Number :	12779		
P.O. Number :		Part Number :	D350600242
This Issue :	12/05/2008	Drawing Number :	IIN REV.C PG11,18-21
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	C
Previous Run :	35398	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :	JLD 08.5.12	Qty:	1 Um: Each
Comment :	Est Rev:A 07.03.07 - new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.5.13



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

JLD 08.5.13

2.0 39188A SPACEPOD BODY RH


 Comment: Sub-Component SPACEPOD BODY RH
 D3188-2M Batch: 39188A

AS 080826

3.0 39188B SPACEPOD DOOR RH


 Comment: Sub-Component SPACEPOD DOOR RH
 D3186-4 Batch: 39188B

AS 080826

4.0 D31872 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

 Qty Part Number Description Batch
 1 D3187-2 Floor 331836

AS 08/07/08 (K1)

5.0 ALS41032130 Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

insert

batch: M105819

AS 08/07/08 (K1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Washer - Countersunk

M106150

JS 08/07/08 (X)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

JS 080826
BR 08-08-26

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-09-22
f.t test.

9.0

D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)
neoprene foam
batch: 30632

JS 08/07/08 (X)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

JS 080826

11.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Lock Nut
batch: 39563

JS 08/07/08 (X)

12.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
BALL STUD

37674

JS 08/07/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH:

107959

JS

08/07/08 (X)

14.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

31128

JS

08/07/08 (X)

15.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch:

38807

JS

08/07/08 (X)

16.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch:

3459

JS

08/07/08 (X)

17.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch:

35454

JS

08/07/08 (X)

18.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch:

30630

JS

08/07/08 (X)

19.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch:

M104603

JS

08/07/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M107650

AS 08/07/08 (X)

21.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M107990

AS 08/07/08 (X)

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step separates hardware, previous steps is for body & floor****

23.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104427

AS 08/07/08 (X)

24.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M107650

AS 08/07/08 (X)

25.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M107101

AS 08/07/08 (X)

26.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107990

AS 08/07/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total: 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch:

35433

AS 08/07/08 (X)

28.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DECAL

batch:

B39678

AS 08/07/08 (X)

29.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Door Latch

batch:

38174

AS 08/07/08 (X)

30.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Latch Clamp

batch:

38813

AS 08/07/08 (X)

31.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Latch Plate

batch:

33894

AS 08/07/08 (X)

32.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

M100903

AS 08/07/08 (X)

33.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch:

M105442

AS 08/07/08 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Nut
batch: M107665

JS 08/07/08 (X)

35.0	D28571	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Hinge Bracket
batch: B38680

JS 080825

36.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Hinge Bracket
batch: 39786 36924

JS 08/07/08 (X)

37.0	D2228	Bracket Plate
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Backing Plate
batch: 30679

JS 08/07/08 (X)

38.0	AN526C832R10	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Screw
batch: M164603

JS 08/07/08 (X)

39.0	AN960JD8	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)
Washer
batch: M107650

JS 08/07/08 (X)

40.0	MS21042L08	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)
Nut
batch: M107990

JS 08/07/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET

batch:

32647

JS 08/07/08 (X)

42.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

9216

Batch not in comp

JS 08/07/08 (X)

43.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

M104603

JS 08/07/08 (X)

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: M107908 expire date: 090320

A/R Milled fibres batch: M100859

2 -> Prime as necessary (Grey) per QSI005 M109241

3 -> Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: M105623

JS 080827

JS 080826

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 080925 (X)

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M109219

JS 08-09-25

(X)

Dart Aerospace Ltd

W/O: 39188		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-09-25	44.0	A prime (Grey) step will need to be needed to 44.0, to prime as necessary. per Q51005 with primer B #'s hardener B #'s. M10924/	M/10924/	08-09-25			
		Perm. Change				08-09-25	08-09-25
		ESTIMATE # 12779		08/09/30			

Part No: D350-600-242 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SPACEPOD ASSEMBLY-RH/ DSI 9335

Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M.A. 08/09/26 (X)

48.0

K10021

Spacepod Hardware Kit (-24)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

36203

JS 08/07/08 (X)

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/01/06 EC
08/07/08 (X)

50.0

D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SWITCH RELOCATION KIT

B 36037

JS 08/07/08 (X)

51.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label
batch: 32470

JS 08/07/08 (X)

52.0

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: 35455

JS 08/07/08 (X)

53.0

D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
STRUT
batch: 32450

JS 08/07/08 (X)

54.0

D35527

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CARBON STEEL GAS SPRING
batch: 32644

JS 08/07/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 39188

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BALL STUD

batch: 37674

AS 08/07/08 (X)

56.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch: 107959

AS 08/07/08 (X)

57.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lock Nut

batch: 39563

AS 08/07/08 (X)

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/09/06 (X)

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: B

PPP Rev: B

AS 08/26/08

60.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30/08

Job Completion



MF 08-09-26

B 39188

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

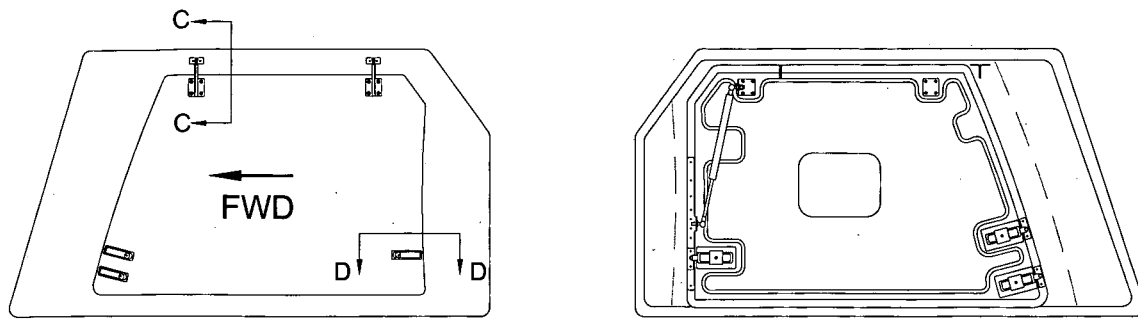


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

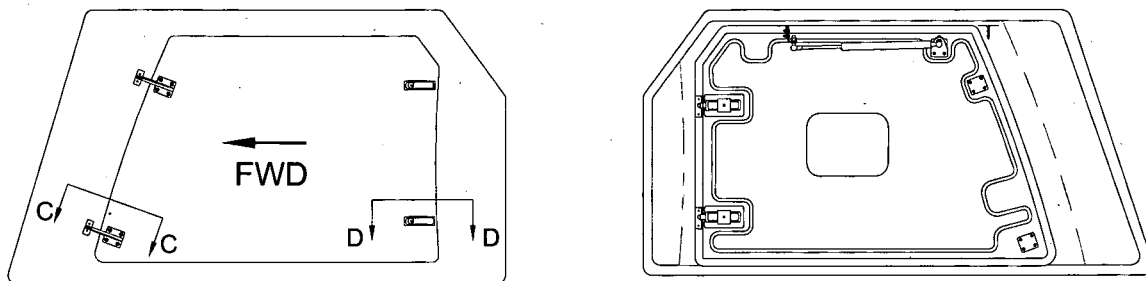
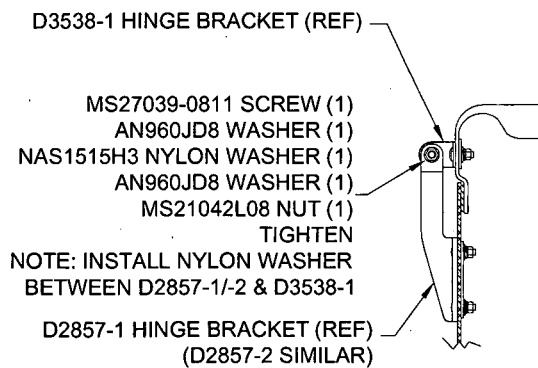
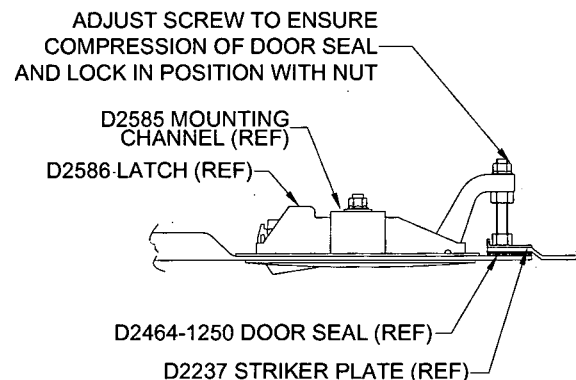


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39188

3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.

3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

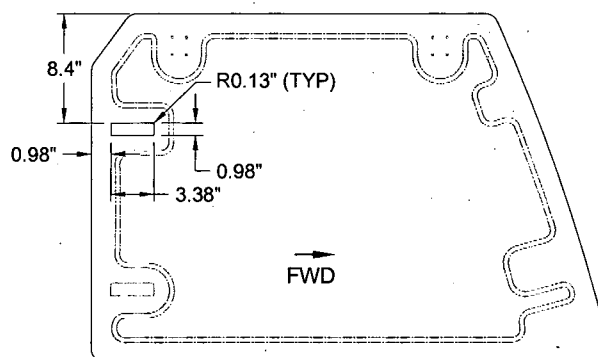


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

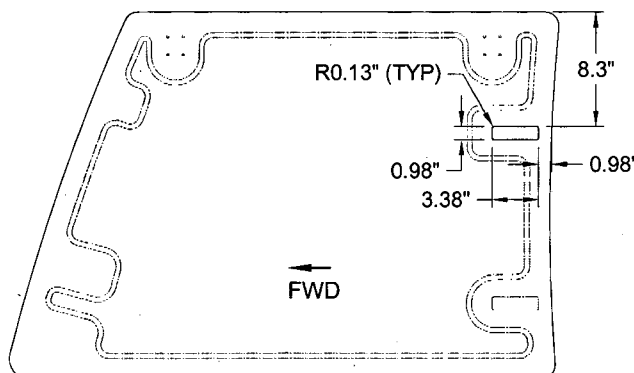


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

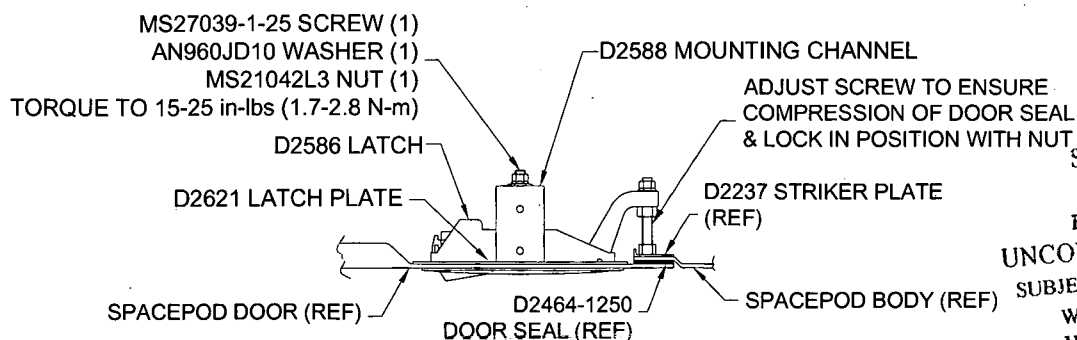


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39188

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

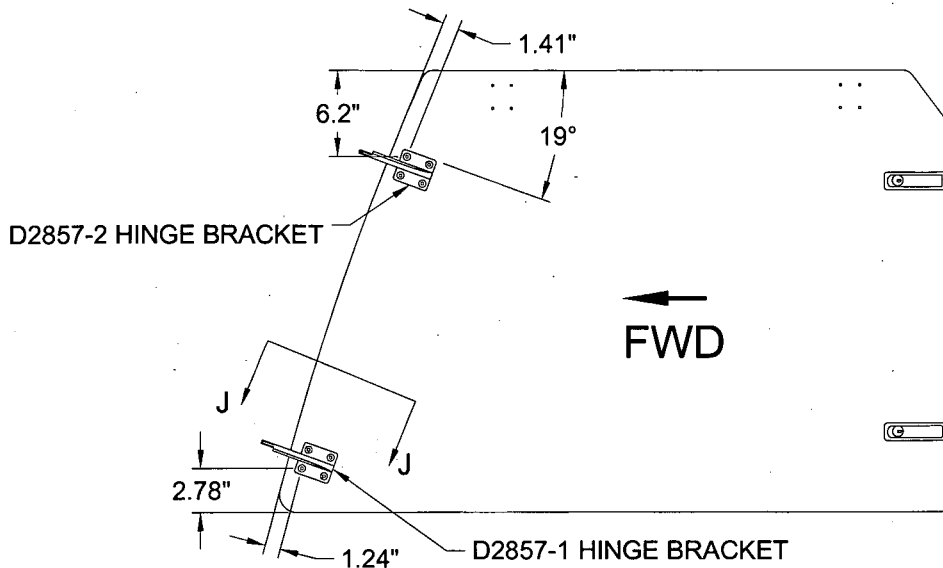


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

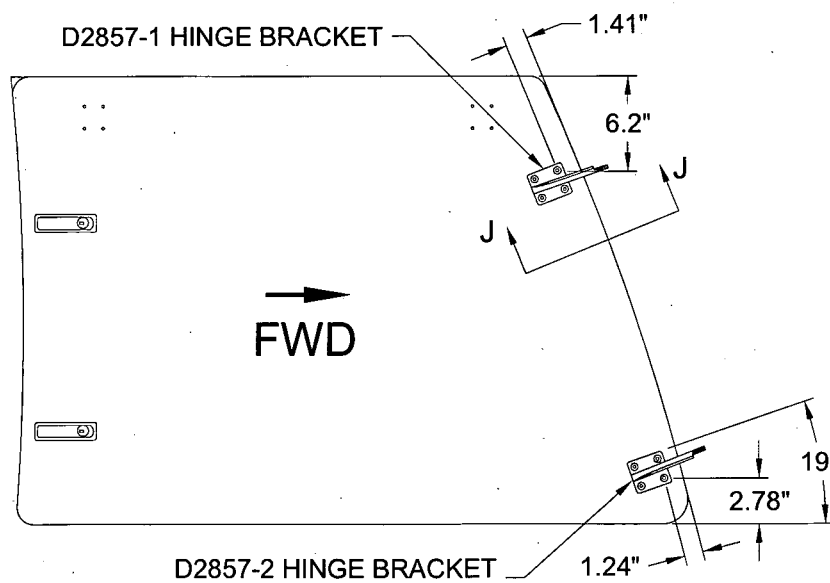
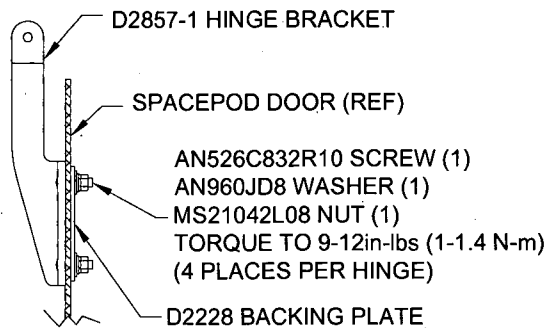


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

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SECTION 'J-J' HINGE BRACKET INSTALLATION
 (D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

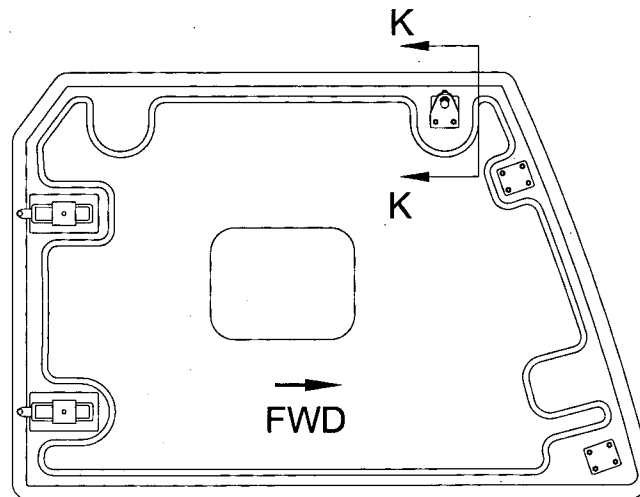
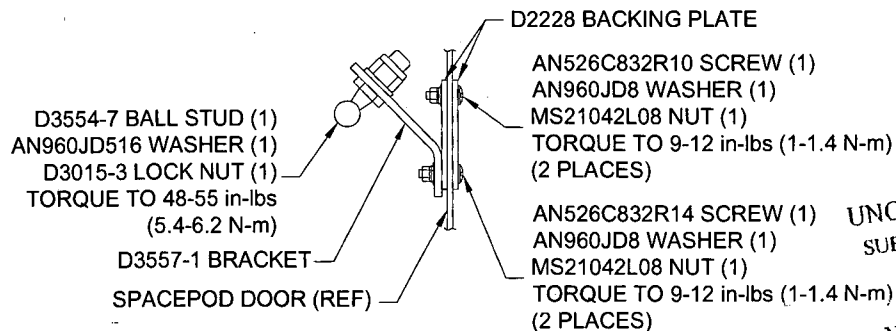


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
 (INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



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SECTION 'K-K'

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Revision: **C**
 Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill $\varnothing 0.375$ " holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the $\varnothing 0.172$ " D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

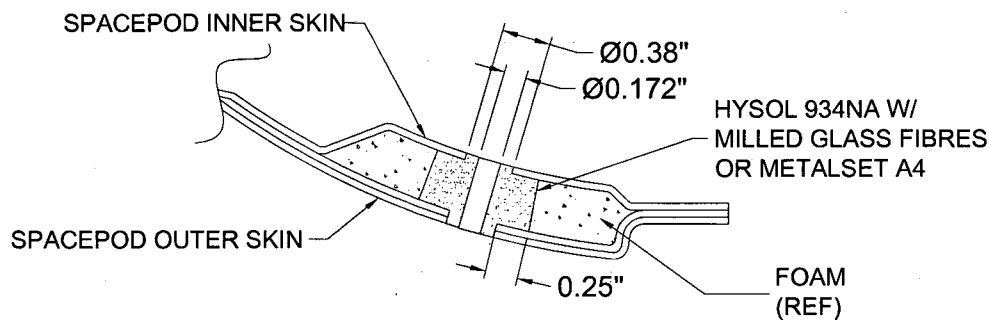


FIGURE 17(a). COMPOSITE MODIFICATION

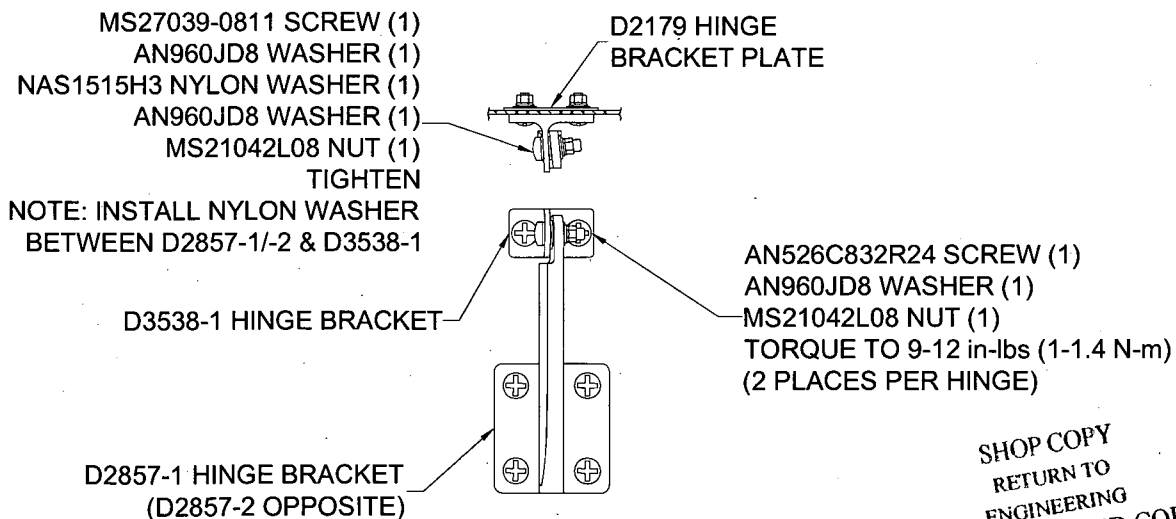


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
			1	1			1		D2464-0360	NEOPRENE SEAL
									D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								3	M81824/1-2	SPLICE
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2				
2**	2**	2**								
4**	4**	4**			4	4				
4**	4**	4**			4	4				
4**	4**	4**			4	4				

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD C

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD

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MS20426AD4-4
M1021

Date: Monday, 12/05/2008 10:00:50 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY RH
Job Number :	39188A		
Estimate Number :	12596		
P.O. Number :		Part Number :	D31882M
This Issue :	12/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3188 REV.E
First Issue :	/ /	Project Number :	N/A
Previous Run :	35396A	Drawing Revision :	E
Written By :		Material :	
Checked & Approved By :	<u>Julie Lecocq</u>	Due Date :	15/06/2008
Comment :	Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec est rev C rev E dwg 07.04.16 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Insert
-----	-------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8	D2213	Spacer
---	-------	--------

Batch:

B 30107

c208/05/13

①

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: 6351

c208/05/13 ①

Description: D3188-2M BODY

SHIP: D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:00:50 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD-BODY-RH

Job Number: 39188A

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

S. Subal

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D350-600-242 B39188

2008-08-25

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.04.02	SPACEPOD BODY	SHEET 1 OF 11
	SCALE	NTS
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES

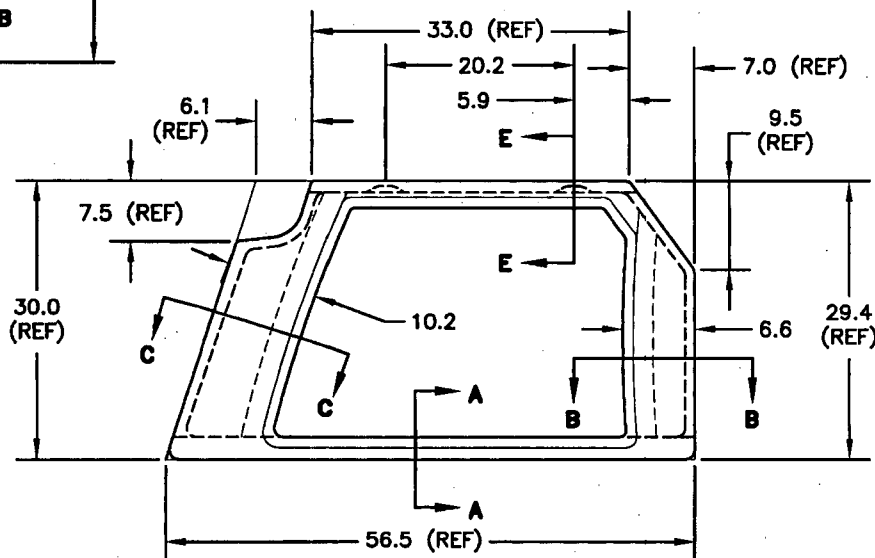
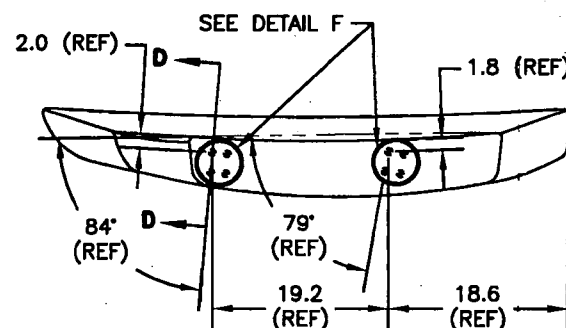
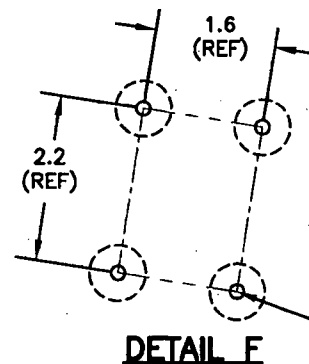
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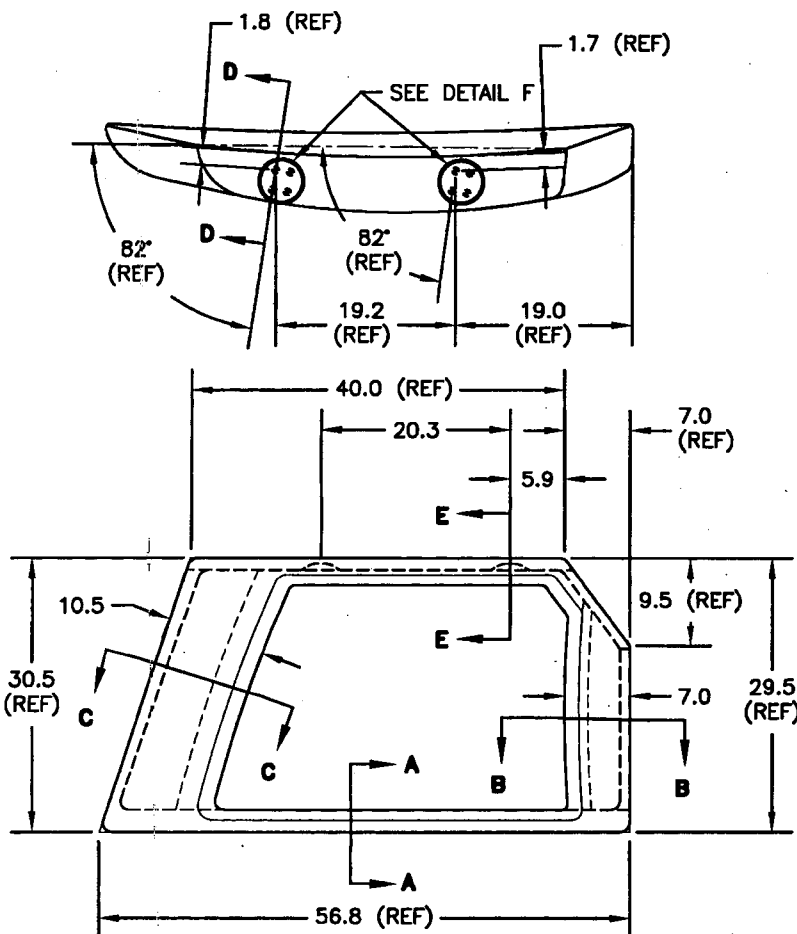
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D3188-1M SPACEPOD BODY

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D3186-1M/-3M NOTES:

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- 2) SEE SHEET #4 FOR SECTION VIEWS.

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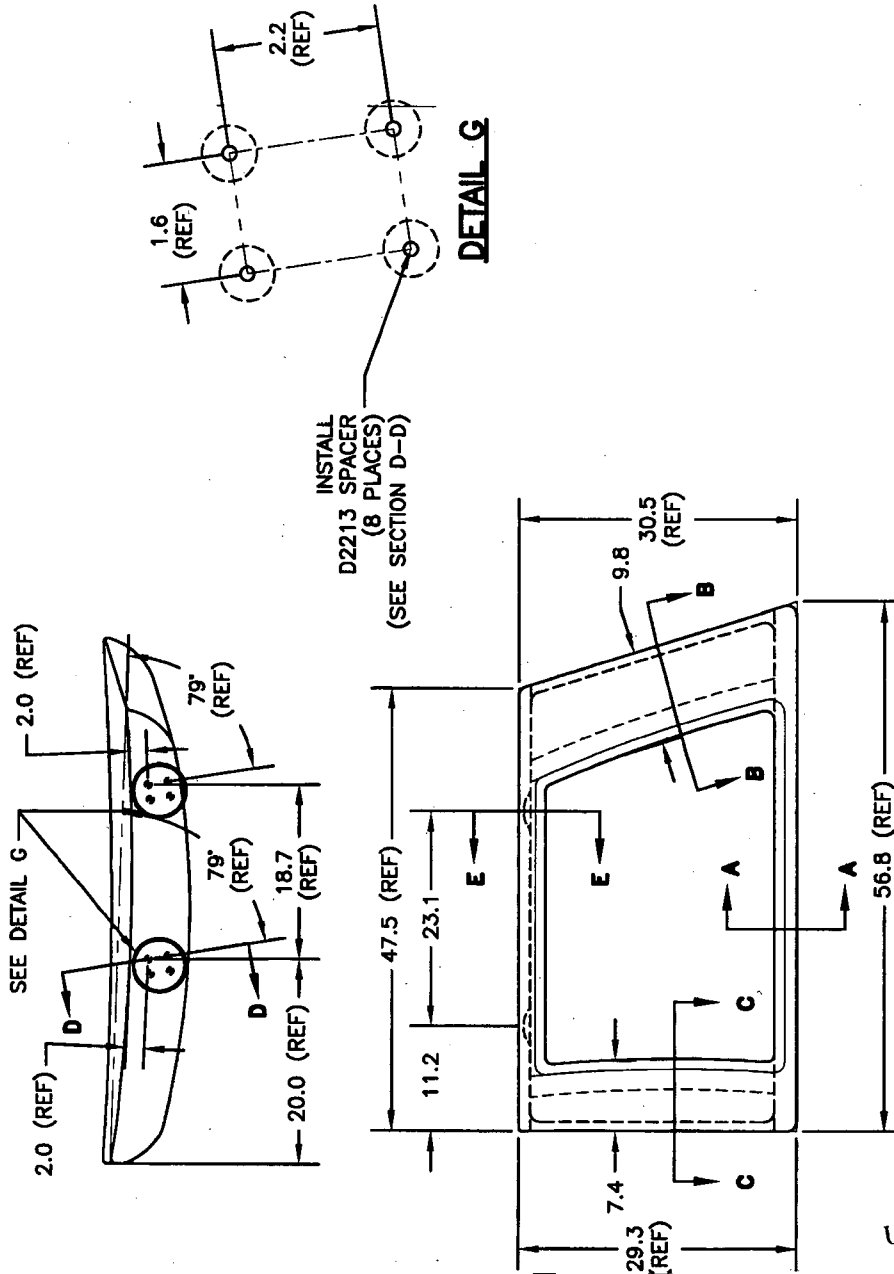
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2) SEE SHEET #4 FOR SECTION VIEWS.

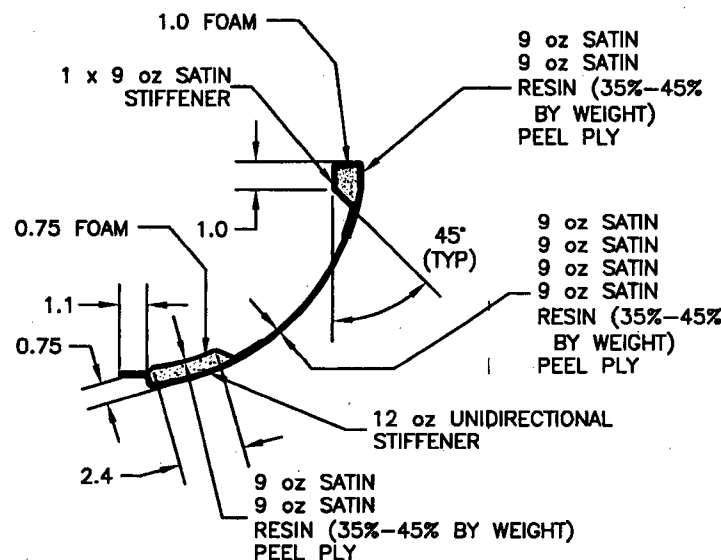
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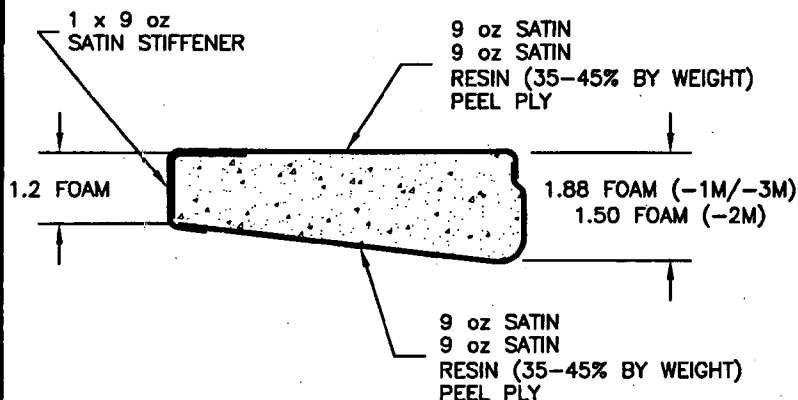
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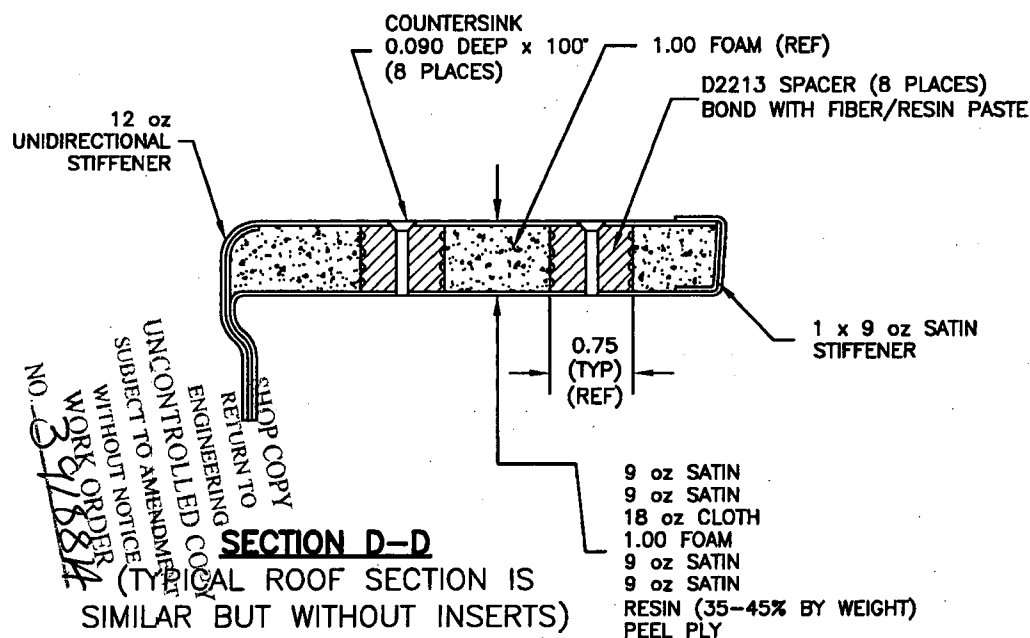
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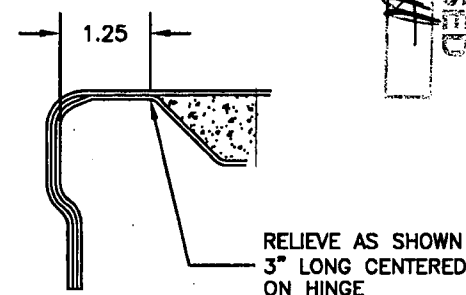
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

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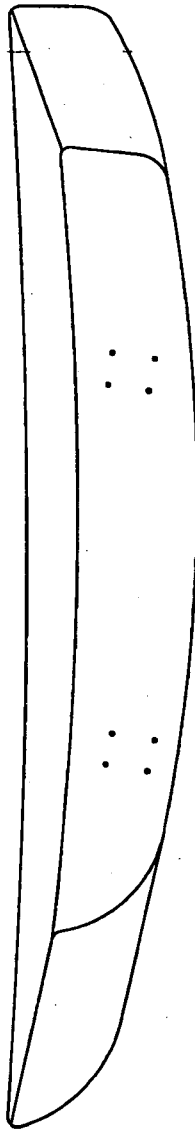
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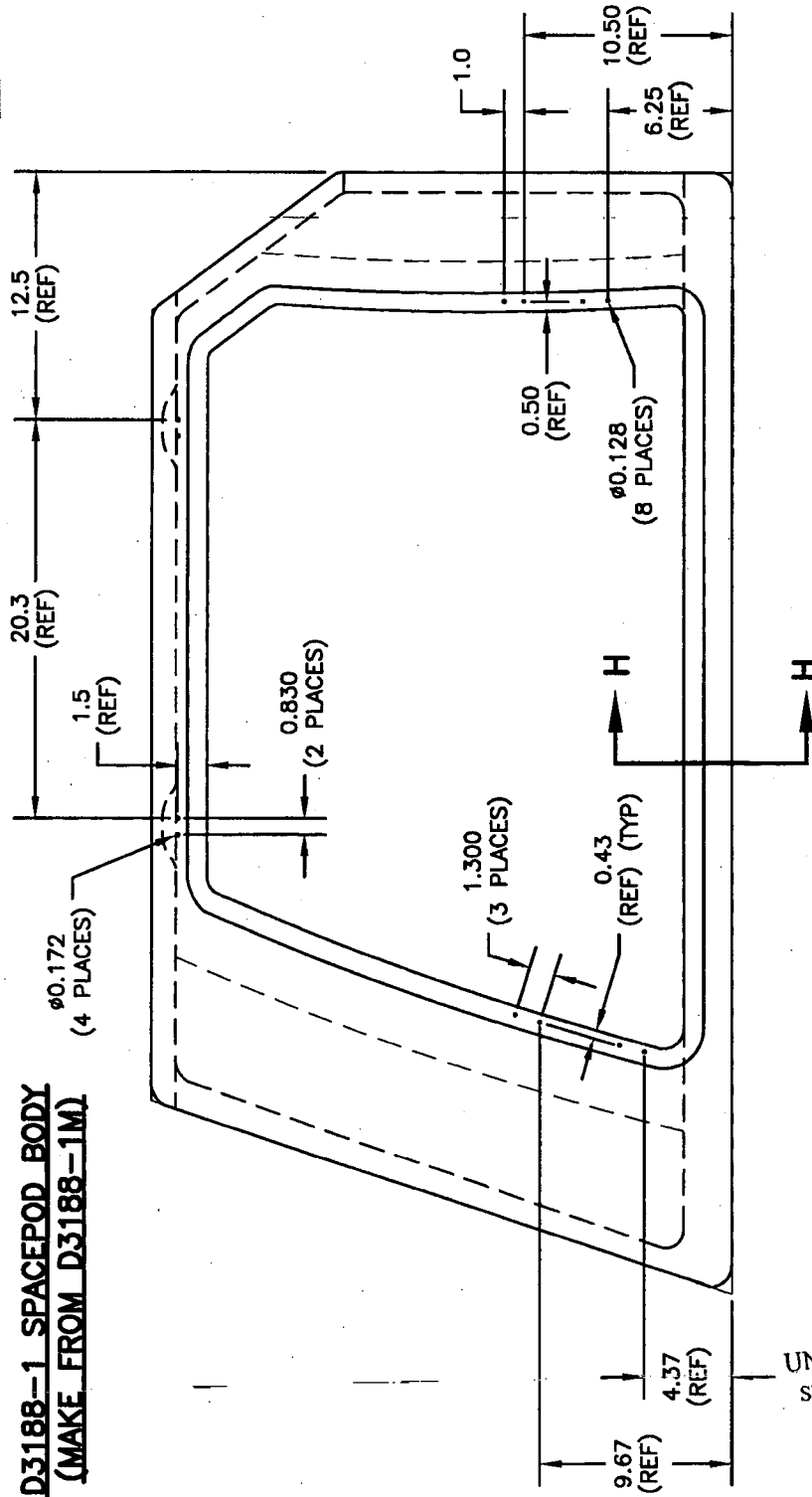
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

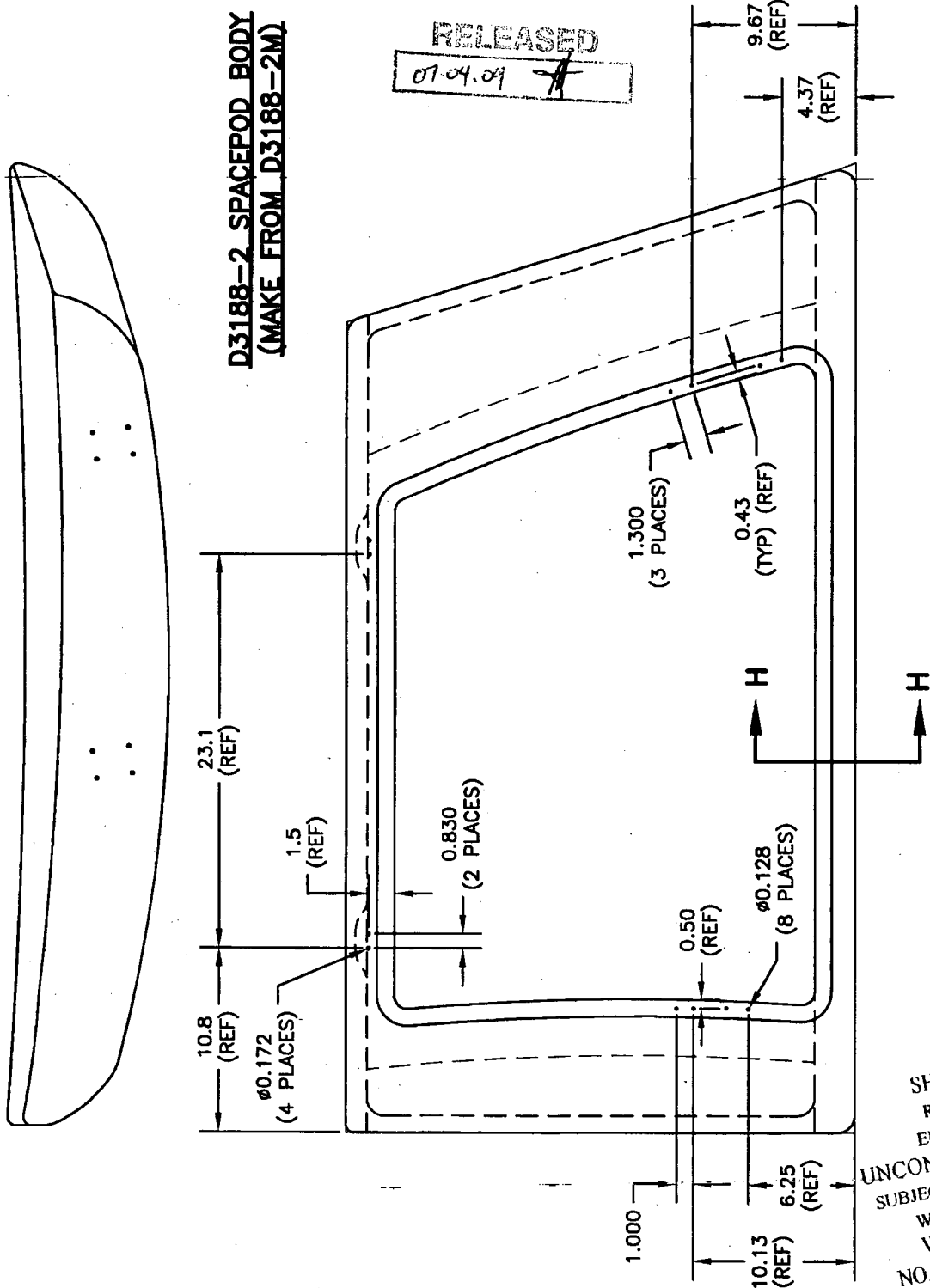
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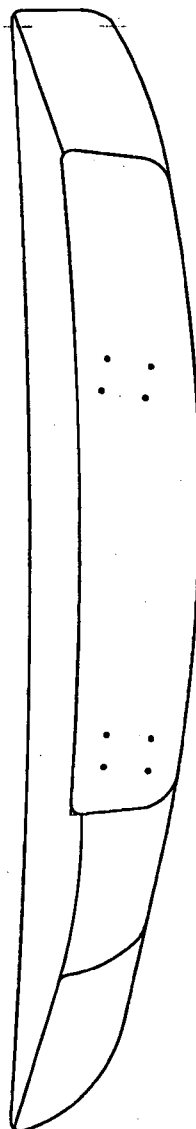
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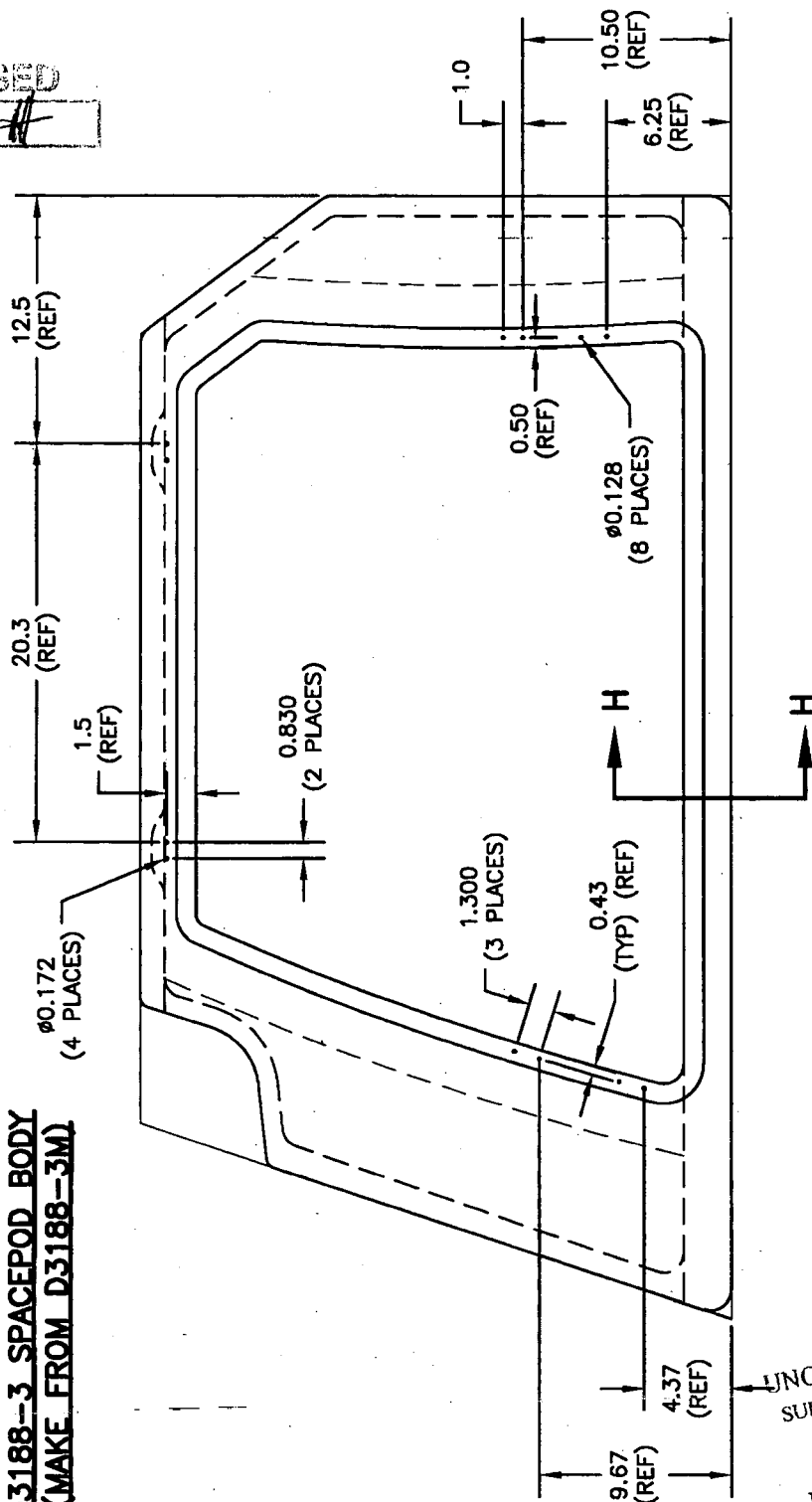


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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
07.04.09 [Signature]



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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WORK ORDER
NO. 39188A

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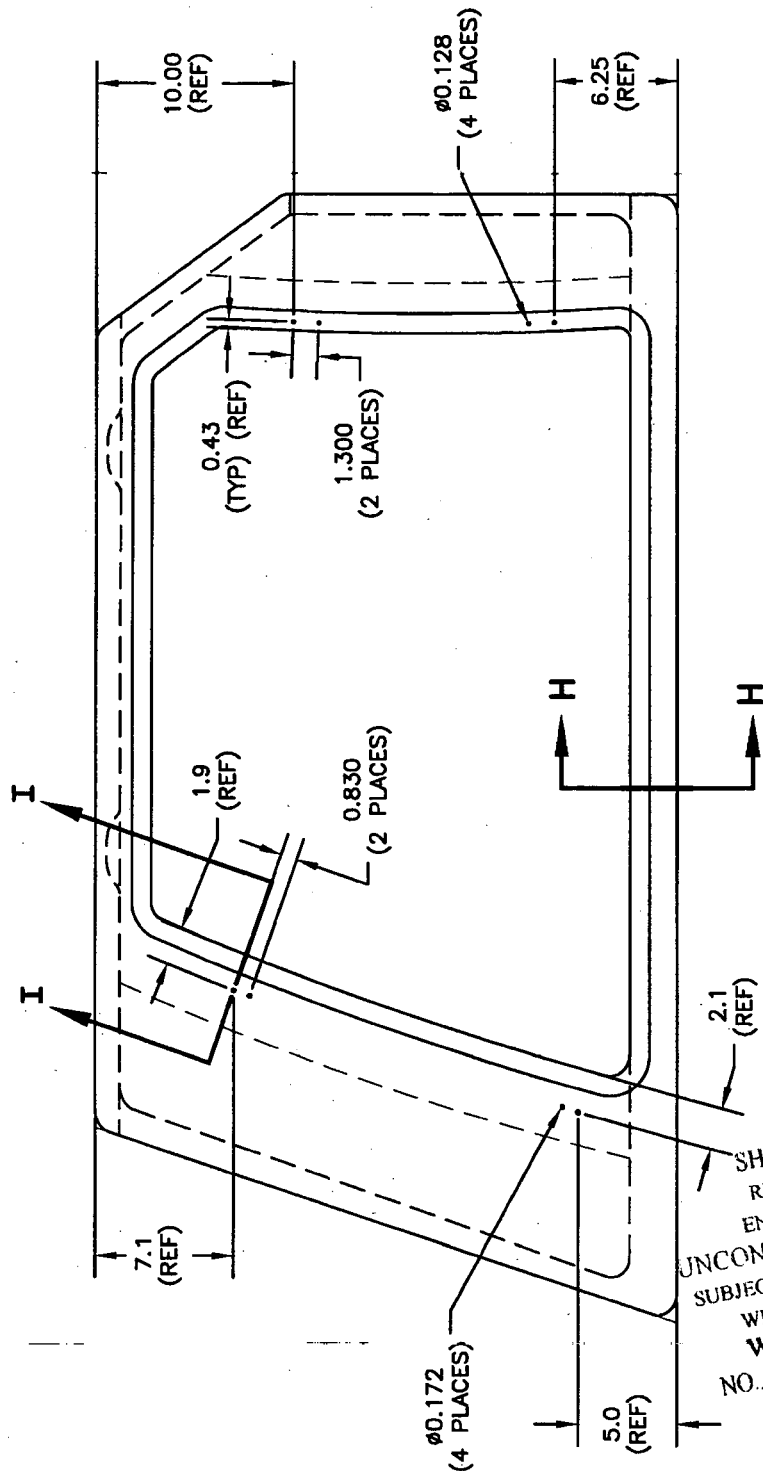
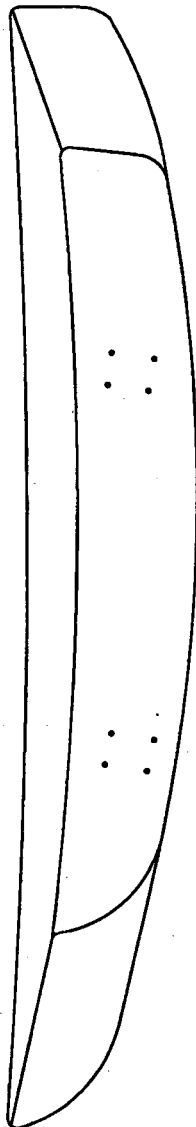
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	SHEET 8 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	

RELEASED

07.04.09

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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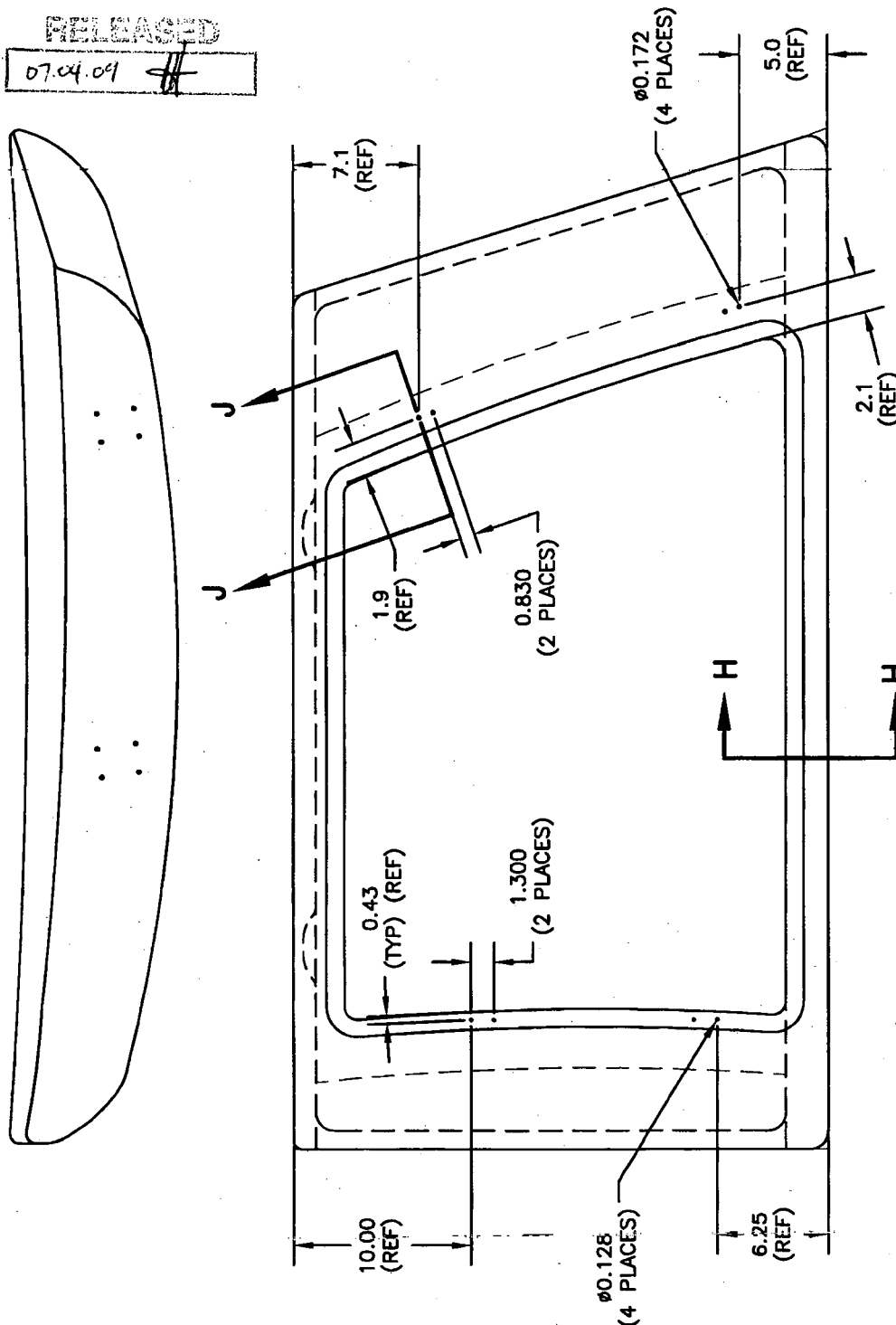
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CHECKED LE	APPROVED #	DRAWING NO. D3188	REV. E SHEET 9 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
07.04.09 **#**

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS
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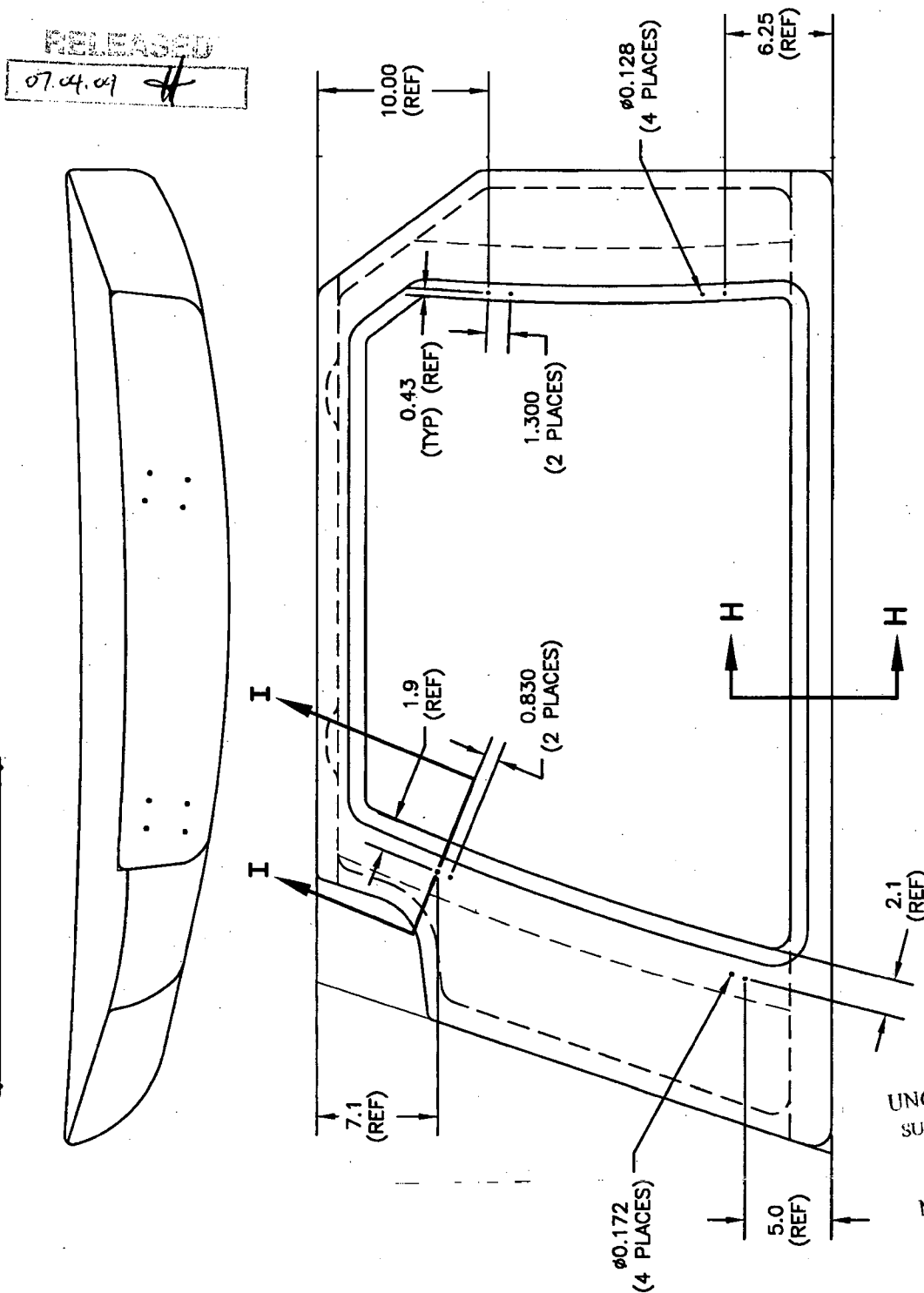
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	SHEET 10 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

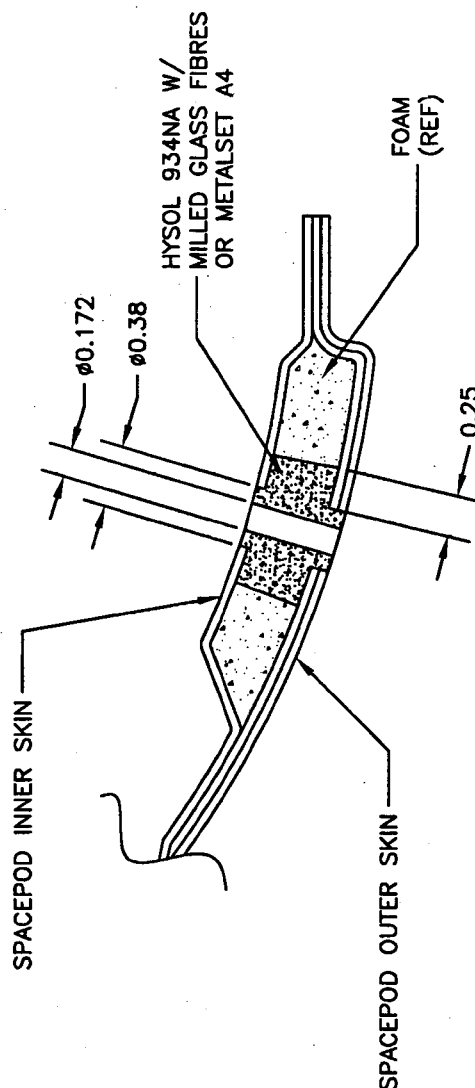
RELEASED
01.04.09 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Monday, 12/05/2008 10:00:50 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD DOOR RH
Job Number :	39188B		
Estimate Number :	12636		
P.O. Number :		Part Number :	D31864
This Issue :	12/05/2008	Drawing Number :	D3186 REV.D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D
Previous Run :	35396B	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :	<u>JULIE LECOQ</u> 08-5-12	Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	39188B01	SPACEPOD DOOR RH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

39188B01

MF 08-09-26

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

080826

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

0809-250

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D353-606-242

B35/88

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

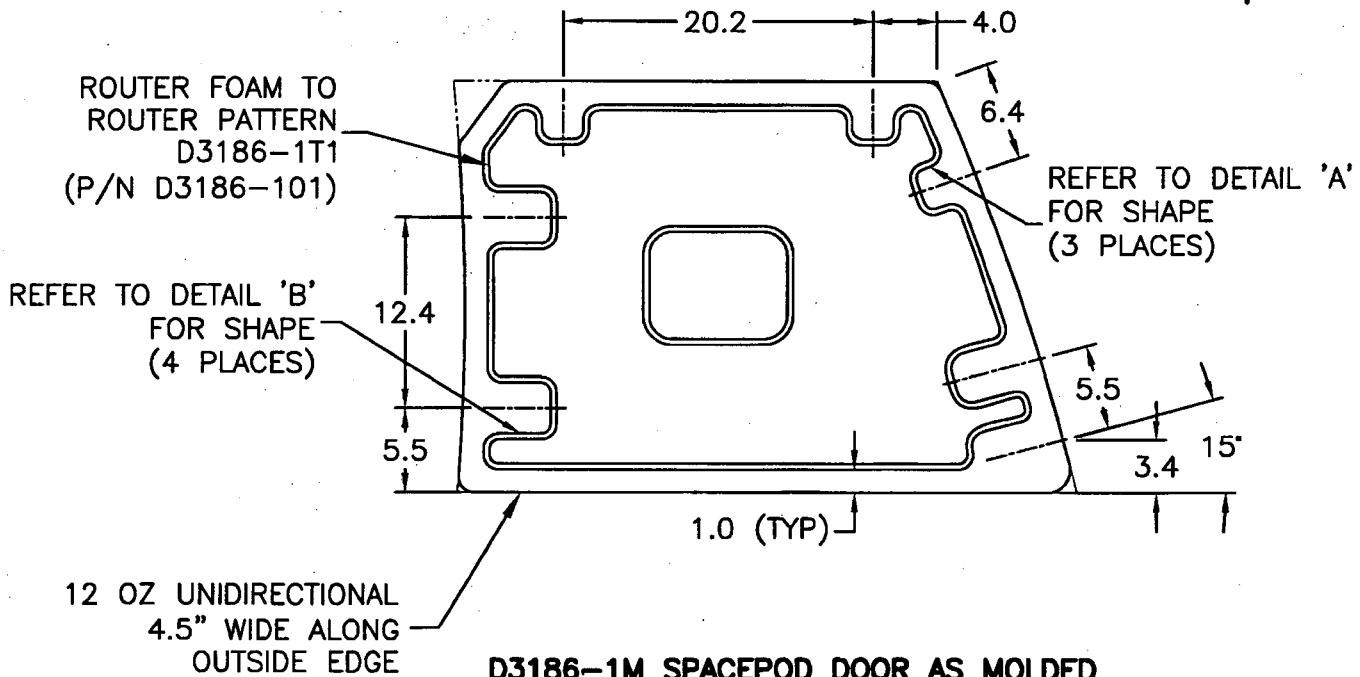
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CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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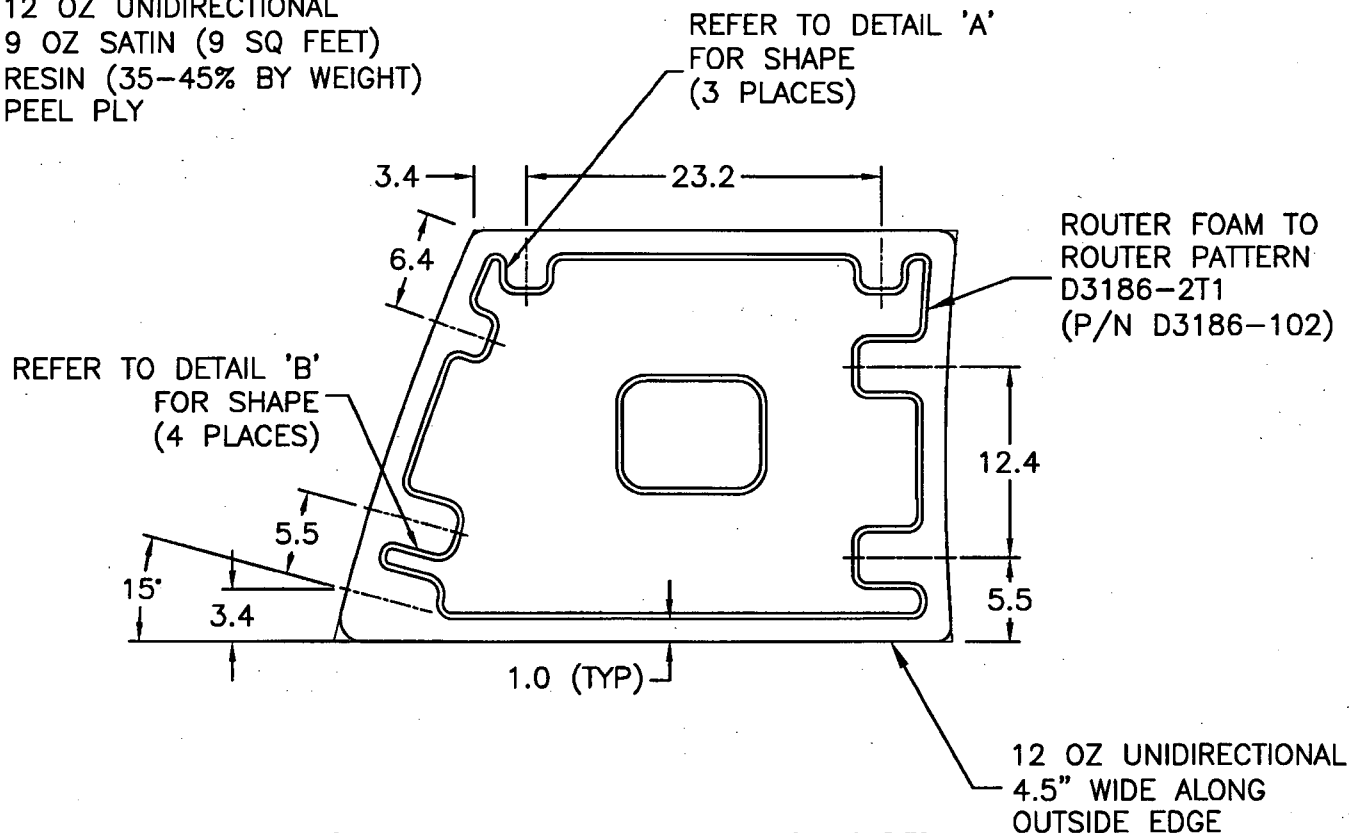
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CHECKED JB	APPROVED JH	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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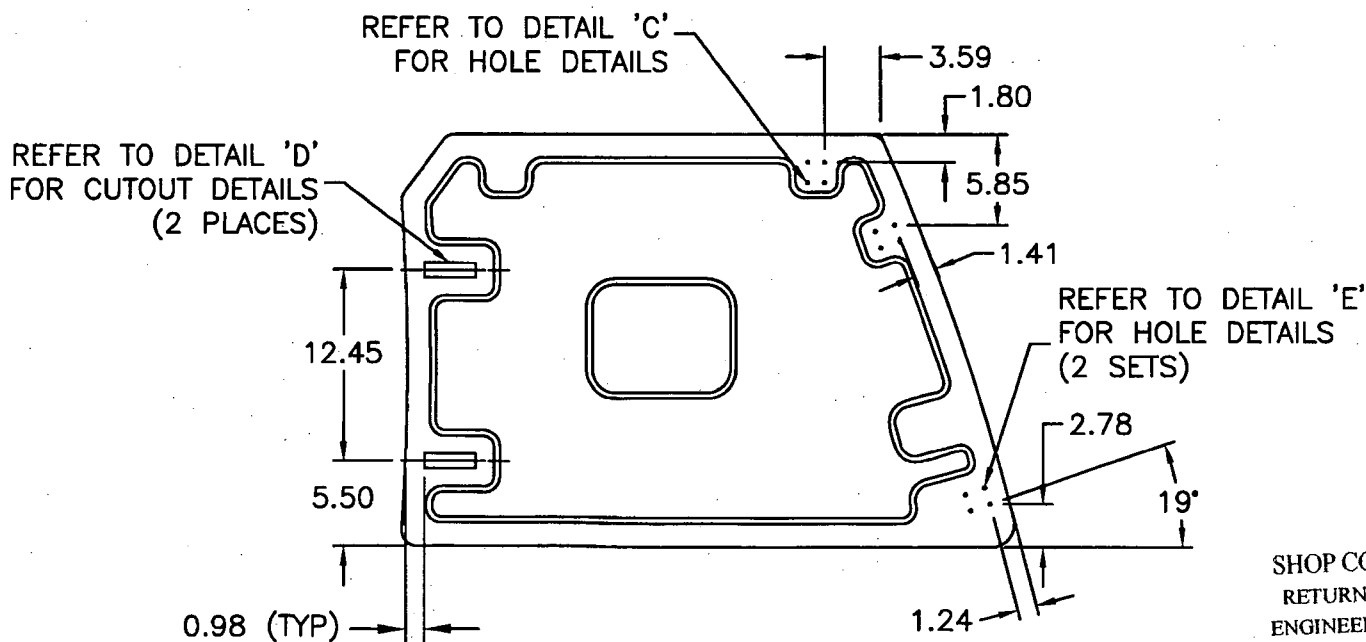
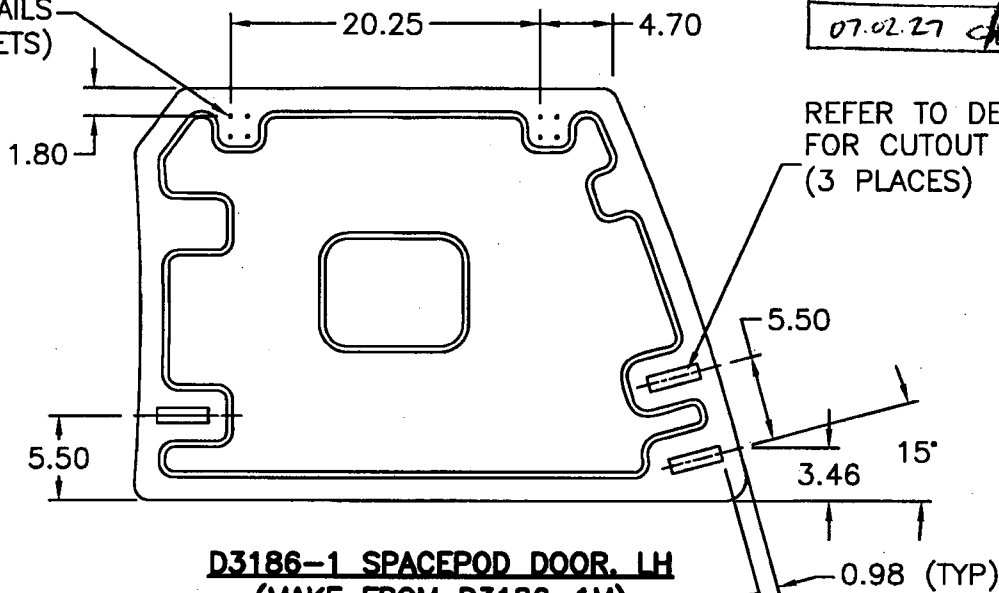
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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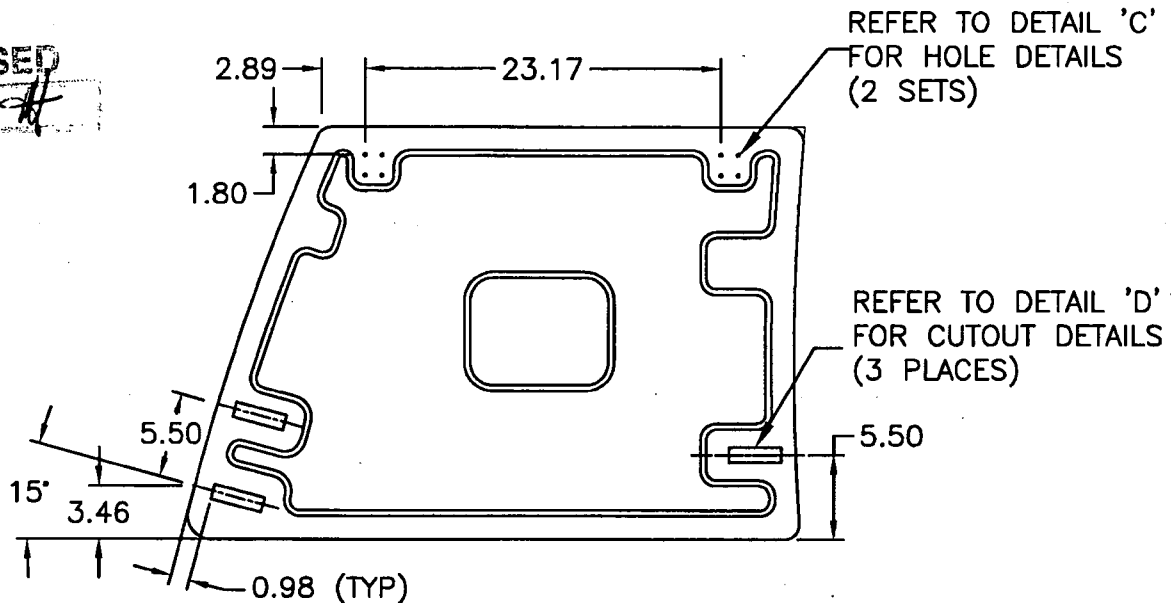
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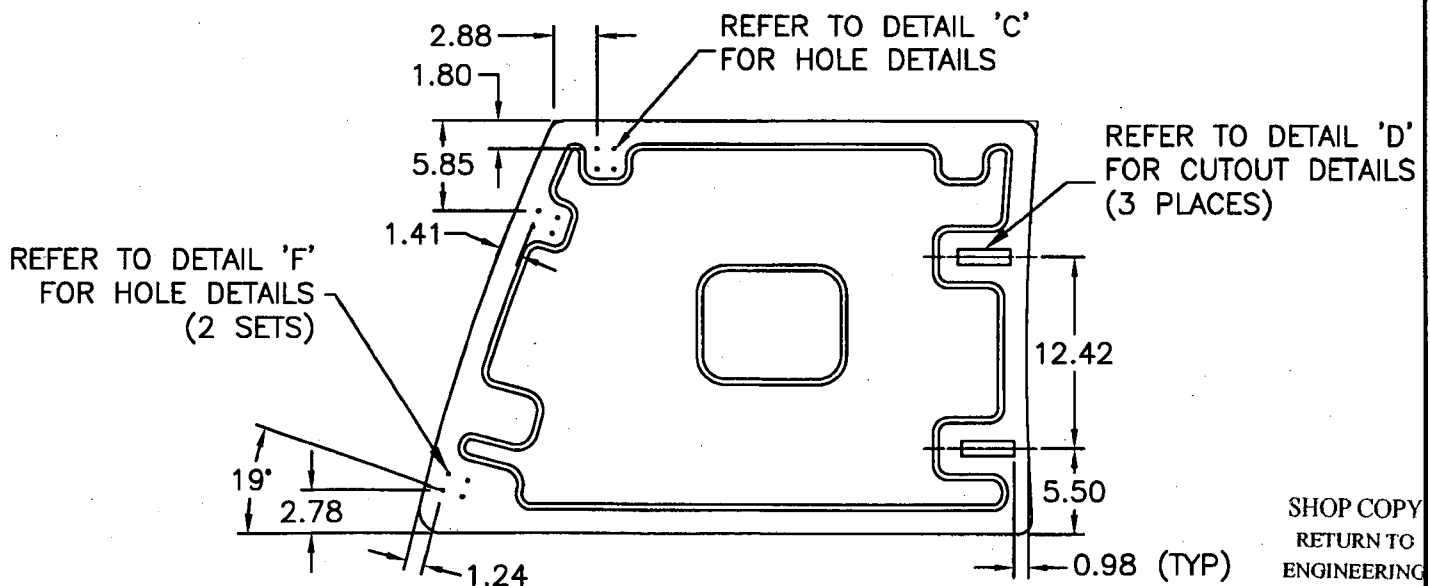
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

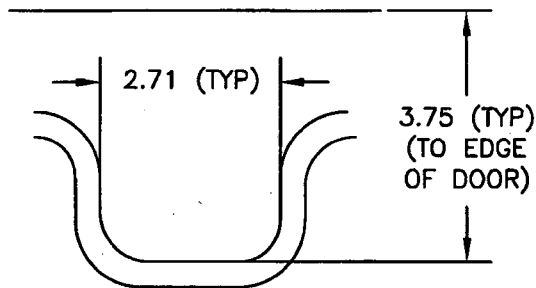
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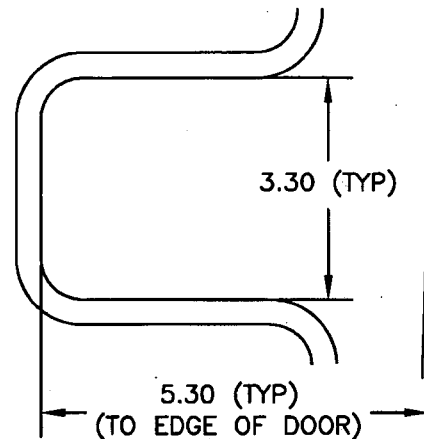
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



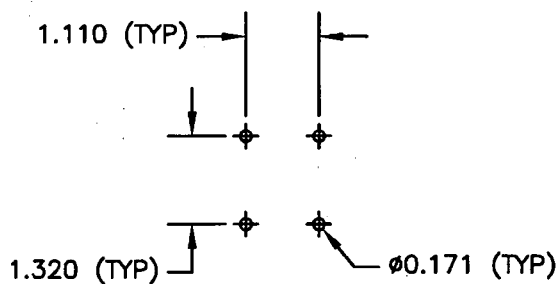
DETAIL A



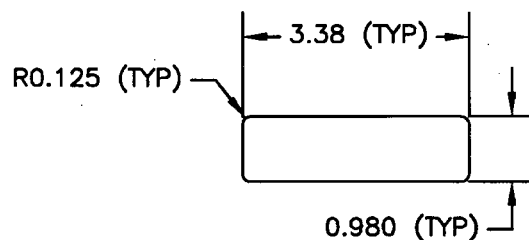
DETAIL B

RELEASED

07.02.22 [Signature]

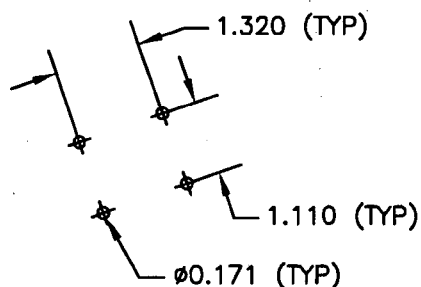


DETAIL C

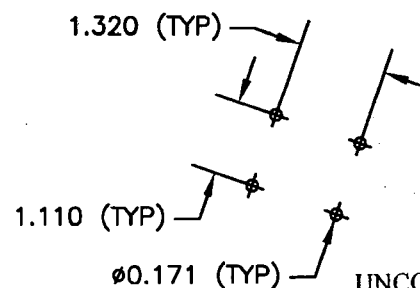


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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Date: Monday, 12/05/2008 10:00:52 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD DOOR RH
Job Number :	39188B01		
Estimate Number :	12599		
P.O. Number :		Part Number :	D31862M
This Issue :	12/05/2008	Drawing Number :	D3186 REV.D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	D
Previous Run :	35396B01	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :	<i>[Signature]</i>	Qty:	1 Um: Each
Comment :	: Est Rev:A New Issue 06-12-04 ec : est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: *6351**CX08/05/13*

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

2.0	D31862P	Spacepod Door
-----	---------	---------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: *B350-600-242 B39188*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:00:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 39188B01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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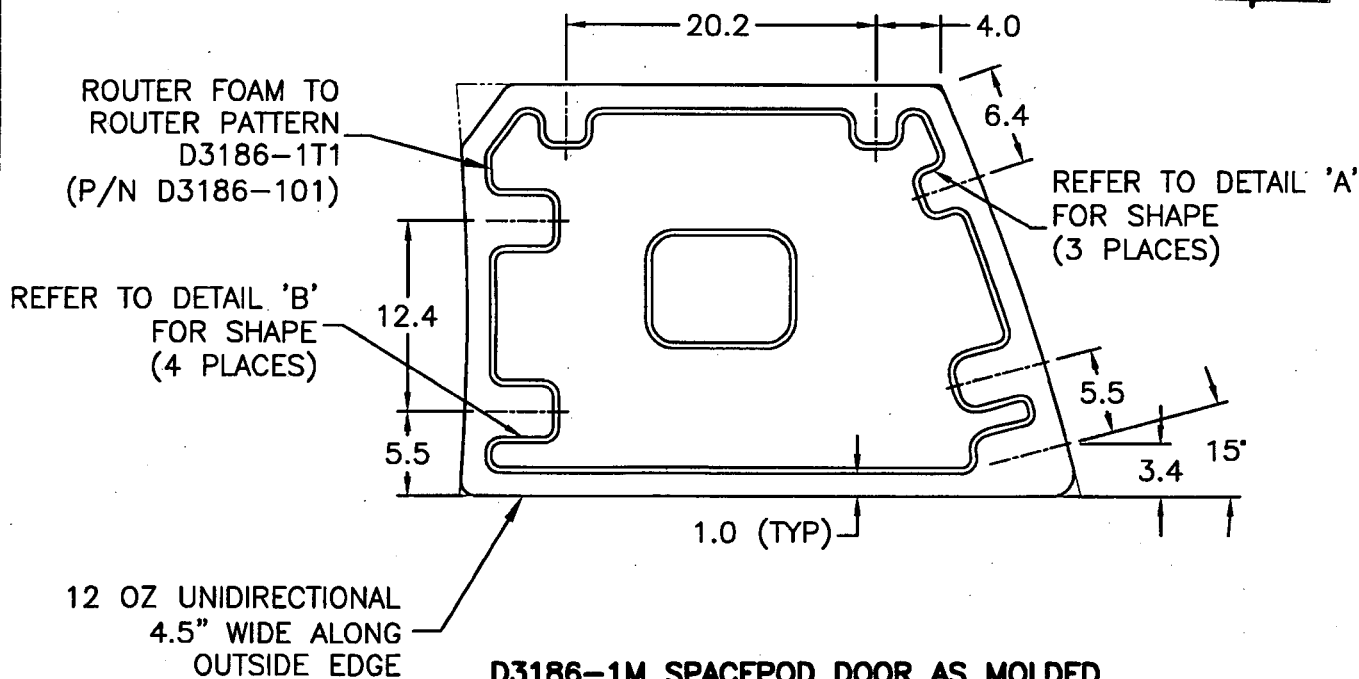
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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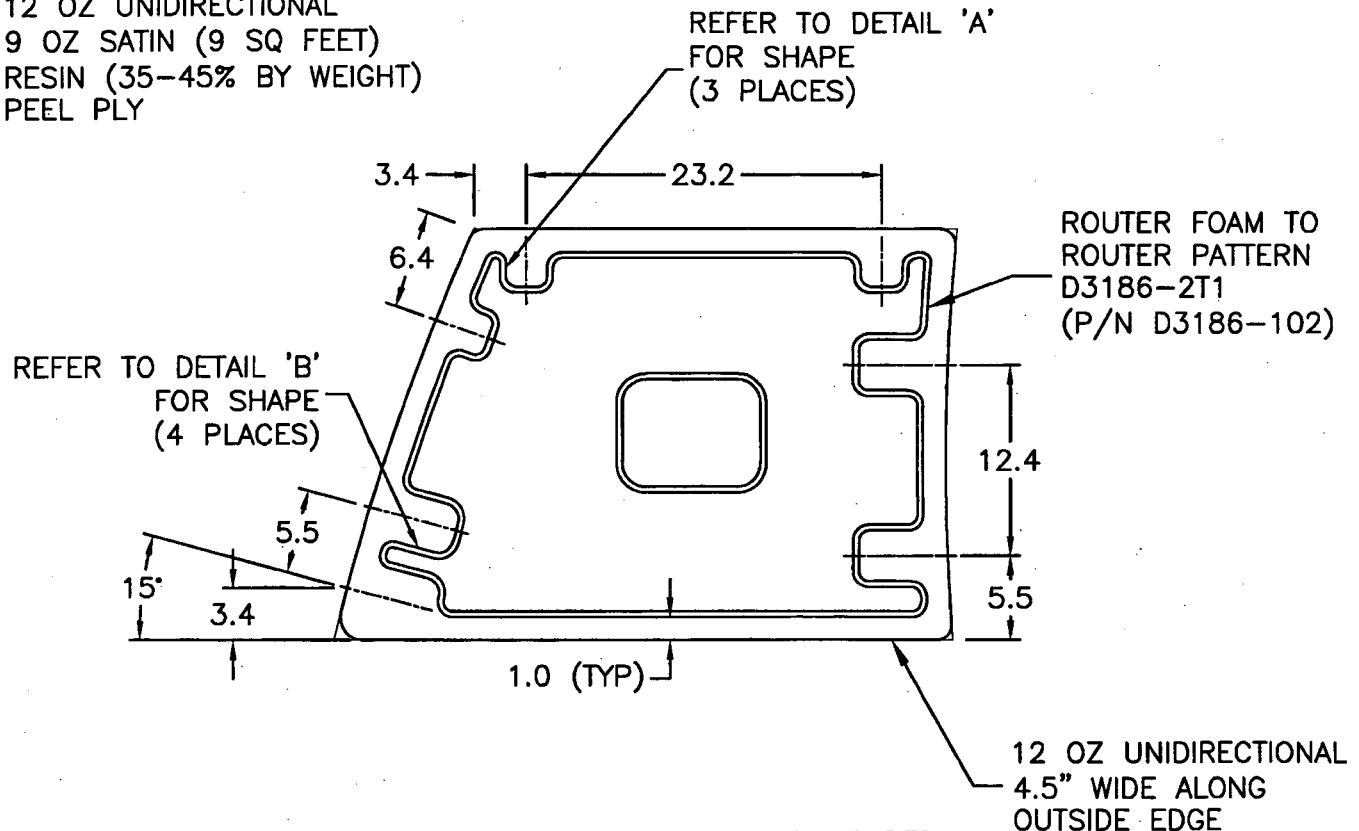
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CHECKED JB	APPROVED JH	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 39188-BD1

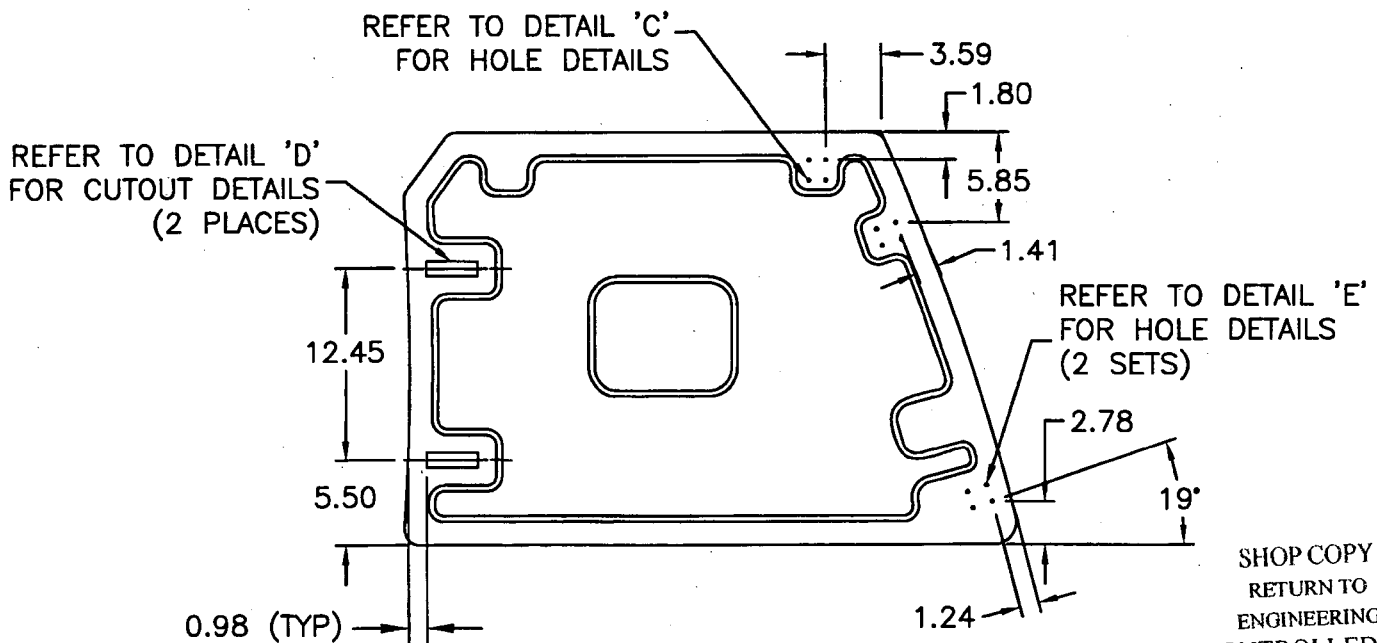
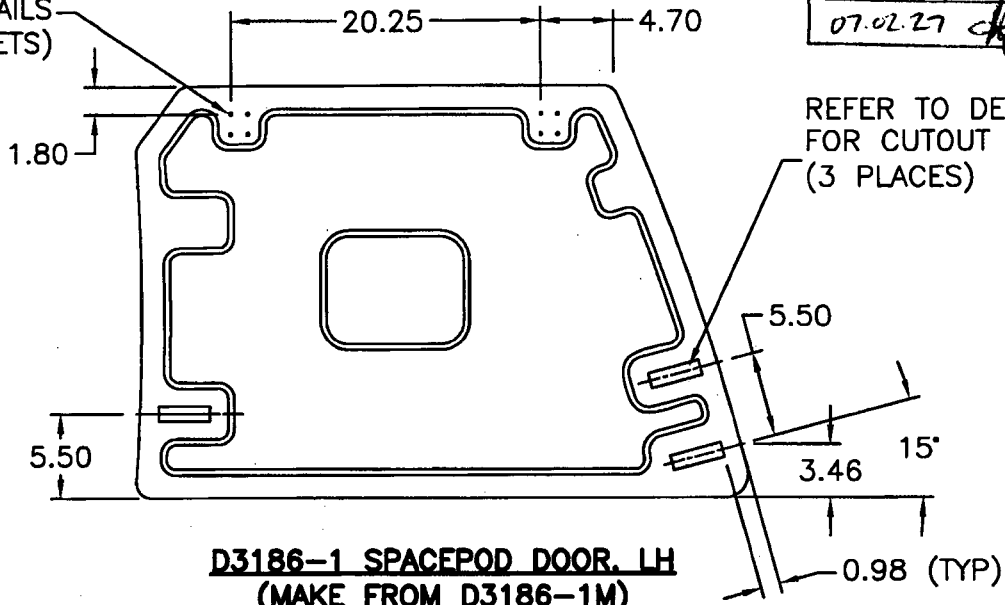
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DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

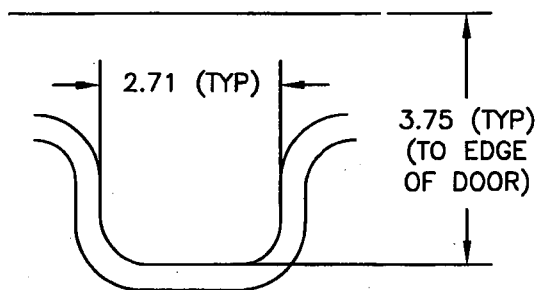
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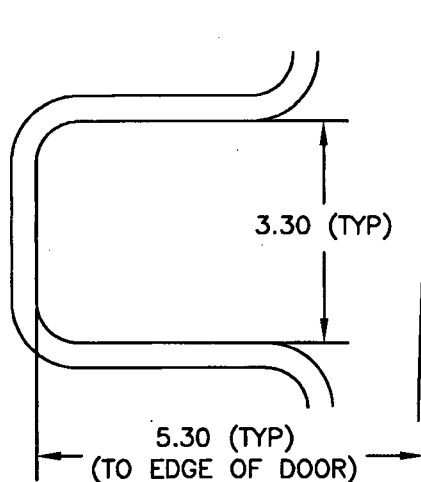
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DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED CH	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



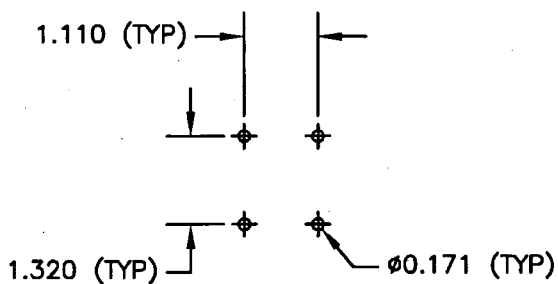
DETAIL A



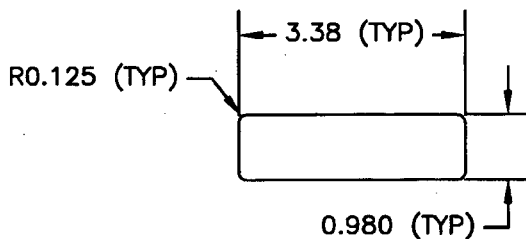
DETAIL B

RELEASED

07.02.27

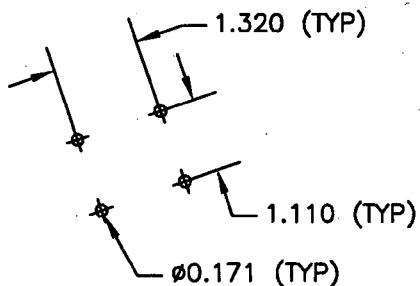


DETAIL C

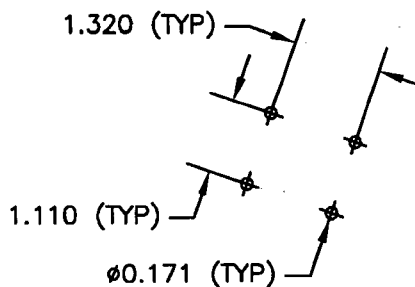


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12745
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #		GST/PST #
09/06/2008	13/05/2008	5796	C. Lavoie		PO00006351		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0060	D31862P Spacepod Door RH B39188B Dwg. Rév.: D <div>No. lot 42353</div> <div>U de M : Each</div>			
1	0	1	DKC134-0055	D31882P Spacepod Body RH B39188A Dwg. Rév.: E Job: 42405 <div>U de M : Each</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.


☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department
DELASTEK
AQ-357

Date: Jeudi, 2007-12-13 11:02:29
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY R/H
Numéro Job :	42405	Numéro Article :	DKC134-0055
Numéro Soumission :	2587	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-12-13 No. B.V. :	Révision dessin :	E
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	-- Type :	Date Due :	2007-12-20 Qté: 1 Udm: UNITE
Job précédente :	42345		
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31882M		

Process Sheet Rév.: 04 Changement le primer Dupont 1104S pour le 7704S

Produit additionnel

Numéro Job:




# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit		Total: 0.050 UNITE(s)
Frekote 44NC		

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: 7/12/07 Heure Début: 4:00 Heure Fin: 4:30 Scou: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 9.84 VERGE(s)/Unit		Total: 9.84 VERGE(s)
Tissu à délaminer Release ply B		

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 9.27 VERGE(s)/Unit		Total: 9.27 VERGE(s)
Wrightlon 5200 Bleu P3		

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit		Total: 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10		

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit		Total: 7.00 VERGE(s)
Stretchlon 200 poche à vide Vert		

Date: Jeudi, 2007-12-13 11:02:29
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 11.400 VERGE(s)/Unit Total : 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#LOT: 1-6170-2

8.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-6170-3

9.0	AAC0633	WR1850 ROVING 18 OZ x 50"
-----	---------	---------------------------

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot: 1-6219-1

10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 11/2/07 Heure Début: 6:00 Heure Fin: 9:00

Sceau: 34

12.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6365-2

14.0	AAC0673	Fibre de verre Miapoxy 66
------	---------	---------------------------

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Jeudi, 2007-12-13 11:02:29
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: 10/12/07 Heure Début: 10:45 Heure Fin: 10:50 Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivelation pour la porter directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-360 sur le moule N° DT 8004 et ensuite imbibé un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 10/12/07 Heure Début: 10:50 Heure Fin: 11:30 Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composants dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 10/12/07 Heure Début: 11:30 Heure Fin: 11:45 Sceau:



Curing Début: 10:45 Curing Fin: 8:00

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Jeudi, 2007-12-13 11:02:29
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler le Foam Core 1" selon le plan de découpe et les gabarits

Date: 11/12/07 Heure Début: 10:30 Heure Fin: 1:00 Sceau:

20.0 AAC0324 Résine (411B7530) 411-350 promo 75min

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME (s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6434-1

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

22.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

11/12/07

23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot: 1-6253-1

24.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

À l'aide du Polybond, coller ensemble les deux surfaces scellées

Disposer des point sur les pièces pour conserver une pression de collage.

Laisser sécher pour un minimum de deux heures.

Quantité: 1 Date: 11/12/07 Sceau:

Date: Jeudi, 2007-12-13 11:02:29
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: Date: Sceau:

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam corn dans le moule selon le dessin.

Quantité: 1 Date: 11/12/07 Sceau:

Quantité: Date: Sceau:

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6434-1

27.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run: 10.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run: 20.0000Hrs
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Date: Jeudi, 2007-12-13 11:02:30
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42405

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

30.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 08333-1

31.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date: 12/12/07 Heure Début: 10:30 Heure Fin: 10:35 Sceau:



32.0 ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 12/12/07 Heure Début: 10:35 Heure Fin: 11:05 Sceau:



33.0 POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: 12/12/07 Heure Début: 11:05 Heure Fin: 11:25 Sceau:



Curing Début: 10:35 Curing Fin: 11:50

Jeudi, 2007-12-13 11:02:30

sateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42405

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération:

Description:

34.0 AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens *ADTECH P-12*

N° de Lot: *19854*



2-06-08 J.S.

35.0 AC0059

Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond

Date: *21-12-07* Heure Début: *11:00* Heure Fin: *11:30* Sceau:



37.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule. *21/12/07*



38.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total: 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: *1-6452-2*

39.0 AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total: 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: *1-6118-3*

40.0 FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au tallage précédant selon I.G. // Sceller le Foam Core

Laisser sécher pendant minimum deux heures.

21-12-07



Date: Jeudi, 2007-12-13 11:02:30

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. --

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42405

Numéro Article: DKC134 0055

Numéro Job:



Séq.: Machine ou Opération: Description:

41.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0504 PINTE(s)/Unit Total: 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75mln.

Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75mln.

N° de Lot: 1-6452-2

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIELFaire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: 21-12-07 Heure Début: 12:30 Heure Fin: 12:35 Sceau: DELASTER COMPOSITES 04

44.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 21-12-07 Heure Début: 12:35 Heure Fin: 1:40 Sceau: DELASTER COMPOSITES 34



45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE

Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Jeudi, 2007-12-13 11:02:30
Utilisateur: Marc Dubé

Feuille de Procédé



Client: DART - Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

Date: 21-12-07 Heure Début: 1:40 Heure Fin: 2:55 Sceau:  


Curing Début: 12:35 Curing Fin: 4:00

46.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 7-1-08 Heure Début: 8:15 Heure Fin: 8:30 Sceau: 


47.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers N° D2213 (ne pas percer la peau extérieur de la pièce)

Date: 7-1-08 Heure Début: 8:40 Heure Fin: 9:40 Sceau: 

48.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

49.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-20176-1

50.0 AAC0673 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-2956-1

Date: Jeudi, 2007-12-13 11:02:30
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date 8-4-08 Heure Début: 10:20 Heure Fin: 10:25 Sceau:



52.0 AAC0448 Spacer N° D2213

Commentaire Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s)

Spacer N° D2213 N° de Lot: 1-6375-4

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer une pression sur les pièces de 9 oz à l'aide d'un bloc de bois et de plaques autobloquantes

Laisser sécher pendant 4 heures minimum.

Date 8-4-08 Heure Début: 10:25 Heure Fin: 11:05 Sceau:



Curing Début: 10:25 Curing Fin: 8:10

54.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6270-1

55.0 AAC0324 Résine (411B7530) 411-350 promo. 75ml.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75ml.

N° de Lot: 1-20176-1

Date: Jeudi, 2007-12-13 11:02:30
Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:




Séq.: Machine ou Opération: Description:

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 13-03-08 Heure Début: 1:30 Heure Fin: 1:35 Sceau: 

57.0 LAMINAGE. LAMINAGE PIÈCE DART




Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce. Selon la dessin.

Laisser sécher pendant 4 heures minimum.

Date: 13-03-08 Heure Début: 1:35 Heure Fin: 2:40 Sceau: 

Curing Début: 1:35 Curing Fin: 8:00

58.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Repercer les 8 trous des spacers afin de les déboucher

15-4-08



Sabler les surfaces de la pièce pour aider à l'adhésion du primer et enlever les imperfections.

59.0 AAC0683 Dupont Primer N° 7704S

Commentaire Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6473-2

60.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 1.0000 PINTÉ(s)/Unit Total : 1.0000 PINTÉ(s)
Dupont Activator N° 7975S

N° de Lot: 1-6473-1

Date: Jeudi, 2007-12-13 11:02:30
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42405

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: N/A

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer une couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer

Laisser sécher pendant 3 heures minimum

Date: 16/12/08 Heure Début: N/A

Heure Fin: N/A

Sceau: 

64.0 AC0058 Polysoft 1.3 kg # 003012 Sikksens

Commentair Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)
Polysoft 1.3 kg # 003012 Sikksens

N° de Lot: 1-6502-1

65.0 AC0059 Durcisseur Polysoft #004009 Sikksens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikksens

66.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide du Sikksens

Faire un léger sablage (Grit 220) de toute les surfaces.

Date: 15/05/08 Heure Début: 2:00

Heure Fin: 4:00

Sceau: 

Date: Jeudi, 2007-12-13 11:02:30

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42405

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

67.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.2500 UNITE(s)/Unit Total: 0.2500 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 1-6518-1

68.0 AAC0670 Dupont Activator N° 7975S 11153

Commentair Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: 1-20215-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)

Dupont Reducer N° 12375S N° de Lot: N/A

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

PRÉPARATION DU MATÉRIEL

MAY 20 2008



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

71.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs

APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant 3 heures minimum

Date: MAY 20 2008

Heure Début: _____ Heure Fin: _____ Sceau: _____



72.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 2-6-08 Sceau: _____ Initiales: G.S.



73.0 EMBALLAGE 3 EMBALLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.

Date: Jeudi, 2007-12-13 11:02:30
Utilisateur: Marc Dubé

Fouille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42405

Numéro Article: DKC134 0055

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 2 juin 08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédure

Client :	DART Dart Aerospace Ltd	Nom Dessin :	SPACEPORT DOOR
Numéro Job :	42353	Numéro Article :	FRK 14-0060
Numéro Soumission :	2610	Numéro Dessin :	11100
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-12-03	Révision dessin :	D
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	--	Date Dûe :	2007-12-10
Job précédente :		Qté :	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31862M		

Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description:

1.0 AC0303 Frekote 44NC

Commentair Qty.: 0.020 GALLON(s)/Unit Total: 0.020 GALLON(s)
Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.



WOLD Date: 21 mai 08 Heure Début: 10:45 Heure Fin: 11:25 Sceau:

3.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total: 3.20 VERGE(s)
Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 6200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total: 3.50 VERGE(s)
Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42353

Numéro Article: DRC-14-0000

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
Commentaire Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s) 9.7 oz Weave #FG-778150-125Y Volan Finish 1-6170-1		
8.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s) Fiberglass 12 oz Unidirectional N° de Lot: 1-6170-3		
9.0	AC0098	Ruban à gommer jaune #: T/AI-2007
Commentaire Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s) Ruban à gommer jaune #: T/AI-2007		
10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchon 200 en laissant le papier sur le côté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 30/10/08 Heure Début: 7 Heure Fin: 7 Sceau:

11.0	AAC0275	Catalyst N° DDM-9
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: 1-6270-1		
12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-20503-1 1-20707-1		
13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 2/mai/08 Heure Début: 12:15 Heure Fin: 12:30 Sceau:

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42353

Nom Dessin: DPACT-PUB-0001
Numéro Article: DRC134-0000

Numéro Job:



Séq.: Machine ou Opération: Description:

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 21 mai 08 Heure Début: 12:50 Heure Fin: 1:10 Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1007Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composants dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 21 mai 08 Heure Début: 1:10 Heure Fin: 1:20 Sceau:



Curing Début: 12:50 Fin: 10:05

16.0

AAC0275

Commentaire Qty.: 0.0120 PINTÉ(s)/Unit Total: 0.0120 PINTÉ(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-20707-1

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: SPACEPOD DOOR
Numéro Job: 42353 Numéro Article: DKC134 0000

Numéro Job: 

# Séq.:	Machine ou Opération:	Description:
18.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART 

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL



Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbibor toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 26 mai 08 Heure Début: 12:55 Heure Fin: 1:35 Sceau: NT

19.0	AAC0452	Polybond B46F
Commentaire Qty.: 0.082 KIT(s)/Unit Total: 0.082 KIT(s) Polybond B46F N° de Lot: <u>6324-1</u>		

20.0	DKC134-0057	Foam Core N° D3186-102 (Porte D3186-2)
Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D3186-102 (Porte D3186-2)		
N° de Job: <u>6324-1</u> <u>22017</u>		

21.0	ASSEMBLAGE 3 	ASSEMBLAGE GÉNÉRALE DART 
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Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement du 1/2 oz. positionner le gabarit de bagging dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de bagging.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Faire l'inspection du positionnement par le département de la qualité

Date: 26 mai 08 Sceau: () Initiales: NT

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 26 Heure Début: 1:00 Heure Fin: 1:30 Sceau: ()

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42353

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.16671hs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1 heure 1/2) afin d'enlever le surplus de polybond

Date: 26 mai 08 Heure Début: 11:30 Heure Fin: 2:30 Sceau: _____

Curing Début: 1:00 Curing Fin: 2:30

23.0	AAC0275	Catalyst N° DDM-9
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Commentaire Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: -6290-1

24.0	AAC0324	Résine (411B7530) 411-350 protho. 7min.
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Commentaire Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 protho. 7min.

N° de Lot: 1-20761-1 11-07-08

25.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.08331hs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 29 mai 08 Heure Début: 11:52 Heure Fin: 11:59 Sceau: _____

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42353

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description:

26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 0.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 0.7 oz.

Date: 29 mai 08 Heure Début: 12:35 Heure Fin: 1:10 Sceau: (Signature)

27.0 POCHE À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant.

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures (Signature)

Date: 29 mai 08 Heure Début: 1:10 Heure Fin: 1:25 Sceau: (Signature)

Curing Début: 12:35 Curing Fin: 10:50

28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les "edges".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 30 mai 08 Heure Début: 12:35 Heure Fin: 12:45 Sceau: (Signature)

Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 42353

Nom Dessin: SPACEPOD DOOR
Numéro Article: OPC 134 0000

Numéro Job:



Séq.: Machine ou Opération:

Description:

29.0 TRIMAGE 3

TRIMAGE COMPOSITE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 30/12/07 Heure Début: 12:50 Heure Fin: 1:25 Scéau:



30.0 AAC0683

Dupont Primer N° 7704S

Commentaire Qty.: 0.1390 UNITE(s)/Unit Total: 0.1390 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 65755-1

31.0 AAC0670

Dupont Activator N° 7975S

Commentaire Qty.: 0.2800 PINTÉ(s)/Unit Total: 0.2800 PINTÉ(s)

Dupont Activator N° 7975S

N° de Lot: 1-20611-1

32.0 AAC0672

Dupont Reducer N° 12375S

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: N/A

33.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0 PRIMER

APPLICATION DE PRIMER



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyage 03/16/08



Appliquer une première couche de primer Dupont N° 7704S (7975S Activator, 12375S Reducer) Selon I.G.
Application primer

Laisser sécher pendant 3 heures.

Date: 03/16/08 Heure Début: Heure Fin: Scéau:



Date: Lundi, 2007-12-03 11:42:42
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42353

Nom Dessin: SPACEPOD DOOR
Numéro Article: DCC134 0060

Numéro Job:



Séq.: Machine ou Opération:

Description:

35.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide du papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

36.0

AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-65024

37.0

AC0059

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

38.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 4/12/08 Heure Début: 9:00 Heure Fin: 2:10 Sceau:



39.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1390 UNITE(s)/Unit Total: 0.1390 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6565-1

40.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-2061-1

41.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1/1

42.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MATÉRIEL

JUN 05 2008



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 7704S et ensuite faire le mélange selon les instructions du fabricant.